



CP06-N0031

Polyamide 6

Good Flow, Impact Modified

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Physical	Method	Typical Value	Units
Specific Gravity	ASTM D792	1.11	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.017	in/in

Impact

Notched Izod Impact (.125 in) 73°F	ASTM D256	3.0	ft-lbs/in
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Mechanical

Tensile Strength @ Yield	ASTM D638	5,800	psi
Tensile Elongation @ Break	ASTM D638	10.0	%
Flexural Strength	ASTM D790	12,200	psi
Flexural Modulus	ASTM D790	325,000	psi

Thermal

Deflection Temperature Under Load			
66 psi	ASTM D648	320	°F
264 psi	ASTM D648	150	°F

Information provided is based on typical values from reliable procedures. Values are based on natural or black materials unless otherwise noted. No guarantees or warranties of any kind are expressed or implied. Users are responsible for determining the suitability of the product for their intended application.

Recommended Processing Parameters

Drying Temperature	175°F
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.20%
Rear Temperature	460 - 500 °F
Middle Temperature	470 - 520 °F
Front Temperature	480 - 530°F
Nozzle Temperature	480 - 530°F
Mold Temperature	140 - 180°F

CPPT recommended processing parameters are meant to serve as guidelines only and are not intended to be used for specification purposes. Conditions should be adjusted to optimize material performance with the equipment part design and tooling.