



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

PA6R50N50054

Nylon 6, Medium Viscosity, Natural

Typical Compound Properties	Value / Measure	Test Methods
Physical Properties		
	English Units	
Density	1.13 g/cm ²	ISO 1183
Relative Viscosity	50	
Mechanical Properties		
Tensile Strength	85 Mpa	ISO 527
Rensile Elongation	40 %	ISO 527
Notched Charpy Impact Strength	4.3 kj/m ²	ISO 179/1eA
Thermal Properties		
Melt Point	220 °C	
HDT 264 psi (1.8MPa)	160 °C	ISO 75-1/2

All tests are performed on dry as molded test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.



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General Processing Guidelines

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Typical Processing Conditions		
Process Variable	Description	Values
Temperatures		F C
Barrel	Rear	450 - 520
	Center	460 - 520
	Front	460 - 520
	Nozzle	480 - 520
	Mold	50 - 200
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Drying		
Type		Dehumidifier
Temperature		180°F
Time		2 - 4 hours
Max. % Moisture		0.2
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Special Requirements		
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Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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