



*Technical Data Sheet*  
*General Processing Conditions*

**ResMart Ultra Nylon 6 6**– High performance polyamid 6 6 for injection molding and extrusion applications (Natural)

Technical Data Sheet Properties (ASTM)

Physical Property	Value	Test Method
Specific Gravity	1.14	ASTM D792
Tensile Strength	12,000 psi	ASTM D638
Flexural Modulus	420,000 psi	ASTM D790
Flexural Strength	15,000 psi	ASTM D790
Notched Izod Impact 0.125" @ 73F	2.2 ft-lbs/in	ASTM D256
Unnotched Izod Impact 0.125"	No break	ASTM D256
Tensile Elongation	>10%	ASTM D638
HDT @ 66 PSI unannealed	392 F	ASTM D648
Molding Shrinkage 0.125" section	0.013 – 0.017 in/in	ASTM D955
Water Absorption	1.9%	ASTM D 570

\* Data herein is typical and not to be construed as specifications.

Technical Data Sheet Properties (ISO)

Physical Property	Value	Test Method
Specific Gravity	1.14g/cm <sup>3</sup>	ISO 1183
Melt shrinkage across flow	1.8%	ISO 294-4
Tensile Stress (Yield)	82.0 MPa	ISO 527-2/50
Flexural Modulus	2900 MPa	ISO 178
Flexural Strength	94.0 MPa	ISO 178
Notched Izod Impact (23 <sup>o</sup> C)	4.7 kJ/m <sup>2</sup>	ISO 180
Charpy Unnotched Impact Stength	No Break	ISO 179
Heat Deflection Temperature (.45MPa Unannealed)	200 <sup>o</sup> C	ISO 75-2/B

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Technical Data Sheet Properties (Other)

Physical Property	Value	Test Method
Flammability 0.0280"	V2	UL94
RoHS Compliance	RoHS Compliant	
FDA	FDA Compliant	

## Injection Molding Processing Guidelines

<b>Setting</b>	<b>Value</b>
Drying Temperature	180 F
Drying time	3 - 4 hours
Suggested max moisture	0.18%
Dew point	0 F
Melt temperature	530 - 570 F
Mold temperature	120 - 195 F
Injection Pressure	10,000 – 15,000 psi

**\* Desiccant type dryer required**

The information provided on this datasheet should only be used as a guideline. Actual lot to lot values will vary.

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