



PIEDMONT
resin supply

Product Data & Processing Guidelines
ISO 9001:2015 Certification

Nylamont P635GFHSLBK-P

Nylon 6 – 35% Glass Filled, Heat Stabilized, Black - Prime

<u>Physical</u>	<u>Units</u>	<u>ISO Procedure</u>	<u>Metric</u>
Moisture	%	15512	0.20 max.
Ash	%	3451	33-37
Specific Gravity	-	1183	1.39
<u>Impact</u>			
Izod Impact, notched	kJ/m2	180	13
Charpy Notched Impact	kJ/m2	179	13
<u>Mechanical</u>			
Tensile Strength	MPa	527	183
Tensile Elongation	%	527	3
Tensile Modulus	MPa	527	11200
Flexural Modulus	MPa	178	10500
<u>Thermal</u>			
Melt Point	°C	3146	220
HDT (1.8 MPa)	°C	75	212

Recommended Processing Conditions

Drying Temperature	180°F
Drying Time	2-4 Hours
Maximum Moisture	0.20%
Rear Zones	480-540°F
Middle Zones	500-560°F
Nozzle	520-560°F
Mold Temperature	80-180°F
Melt Temperature	500-560°F
Back Pressure	50 psi

The information provided above is based on laboratory testing using the test methods indicated and is believed to represent nominal results of those tests. Because conditions under which this material may be processed, tested or used cannot be anticipated, no warranty is given, either expressed or implied, as to the accuracy or reproducibility of this information or for the fitness of this material for any particular use. This material is sold with the express understanding that purchasers, processors or other users of this material have sole responsibility, through performance of their own testing, to determine the suitability of this material for any particular use. Additional testing can be provided if required upon request.

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