

## TECHNICAL DATASHEET

**TRAMID<sup>®</sup> 4111U**

PA6

| PROPERTY                                   | UNIT                             | ASTM METHOD | TYPICAL DATA |
|--------------------------------------------|----------------------------------|-------------|--------------|
| <b>PHYSICAL</b>                            |                                  |             |              |
| Specific Gravity                           | -                                | D792        | 1.10         |
| <b>MECHANICAL</b>                          |                                  |             |              |
| Tensile Strength at yield                  | kg <sub>f</sub> /cm <sup>2</sup> | D638        | 620          |
| Tensile Elongation at break                | %                                | D638        | 40           |
| Flexural Strength at yield                 | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 840          |
| Flexural Modulus                           | kg <sub>f</sub> /cm <sup>2</sup> | D790        | 20,000       |
| Izod Impact Strength, notched, 23°C (1/8") | kg <sub>f</sub> ·cm/cm           | D256        | 14           |
| <b>THERMAL</b>                             |                                  |             |              |
| HDT, 18.6 kgf/cm <sup>2</sup>              | °C                               | D648        | 55           |
| <b>ELECTRICAL</b>                          |                                  |             |              |
| <b>OTHERS</b>                              |                                  |             |              |

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

## PROCESSING GUIDE

# TRAMID<sup>®</sup> 4111U GRADE

PA6

- General processing conditions for TRAMID4111U are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

| SPECIFICATION         | UNIT | CONDITIONS |
|-----------------------|------|------------|
| Drying Temperature    | ℃    | 80-90      |
| Drying Time           | hr   | 3-5        |
| Moisture Content, Max | %    | 0.2        |
| Melt Temperature      | ℃    | 240-260    |
| Nozzle Temperature    | ℃    | 250-270    |
| Front Temperature     | ℃    | 250-270    |
| Middle Temperature    | ℃    | 250-270    |
| Rear Temperature      | ℃    | 230-250    |
| Mold Temperature      | ℃    | 50-80      |

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