

ARLEN™ G335

Mitsui Chemicals America, Inc. - *Polyamide 6T*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 35% Filler by Weight
Forms	• Pellets

Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density / Specific Gravity	1.47	--		ASTM D792
Molding Shrinkage - Flow (0.0787 in)	2.0E-3	--	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.0787 in)	5.0E-3	--	in/in	ASTM D955
Water Absorption				ASTM D570
24 hr, 73°F	0.30	--	%	
24 hr, 212°F	1.7	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength	29000	26100	psi	ASTM D638
Tensile Elongation (Break)	3.0	3.0	%	ASTM D638
Flexural Modulus	1.60E+6	1.45E+6	psi	ASTM D790
Flexural Strength	49300	45000	psi	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	1.9	2.2	ft-lb/in	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	536	--	°F	ASTM D648
Glass Transition Temperature	284	--	°F	DSC
Melting Temperature	572	--	°F	
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+16	--	ohms·cm	ASTM D257
Dielectric Strength	710	--	V/mil	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating	HB	--		UL 94

Processing Information

Injection	Dry Unit
Drying Temperature	230 °F
Drying Time	2.0 to 6.0 hr
Hopper Temperature	122 to 194 °F
Rear Temperature	599 to 626 °F
Middle Temperature	608 to 635 °F
Front Temperature	617 to 644 °F
Nozzle Temperature	617 to 644 °F
Mold Temperature	194 to 284 °F
Injection Rate	Moderate
Screw Speed	150 rpm

Injection Notes

Injection Pressure: Medium Pressure

