

Typical Properties of
TUFNYL SXXIC HS NATURAL

PROPERTY	ASTM METHOD	UNIT	VALUE
Mechanical Properties			
Tensile Strength	D-638	MPa	70
Tensile Modules	D-638	MPa	2500
Elongation	D-638	%	18.0
Flexural Strength	D-790	MPa	110
Flexural Modules	D-790	MPa	3000
Izod Impact Strength @ 23 Deg.C - notched	D-256A	Kg.cm/cm of notch	5.0
Thermal Properties			
Melting Point	D-2117	Deg C	220
Heat Deflection Temperature (Un annealed specimens) @ 1.8 MPa load @ 0.45 MPa load	D-648	Deg C	70 140
Other Properties			
Specific Gravity	D-792		1.13
Water absorption (24 hrs in water at 23 Deg.C)	D-570	%	2.0
Mould Shrinkage on Tensile Bar, 3.2 mm, along the flow direction	SRFP	%	1.20-1.40
Rockwell Hardness	D-785	M-Scale R-Scale	75 115
Volume Resistivity	D-257	Ohms-cm	10 ¹⁵
Surface Resistivity	D-257	Ohms	10 ¹⁴
Dielectric Strength	D-149	kV/mm	21
Comparative Tracking Index IEC-112		Volts	>600

All Properties measured at 23 Deg. / 50% RH on dry-as-molded test specimens.
 Only typical data for material selection purposes only. Users have to establish material suitability.

Guidelines for Processing general purpose TUFNYL Grades.

It is recommended to pre dry the Nylon granules in vacuum / air circulated ovens at 100/80Deg.c for 2 - 4 hrs. Using perforated trays.					
Injection Moulding Parameters: Temperature setting in Deg.C					
Feed	Compression	Melting	Nozzle	Melt	Mould
190	225	235	230	220 -240	60 -80

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