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**Technical Data Sheet**

**DYN-N640GM BK**

**Nylon Type 6, 15% Glass Fiber, 25% Mineral Filled Resin**

Typical Compound Properties	Value / Measure		Test Methods
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Physical Properties	English Units	Metric Units	
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Density	1.49 g/cm3	1.49 g/cm3	ASTM D-792
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Mechanical Properties			
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Izod Impact - Notched	0.90 ft-lb/in	48 J/m	ASTM D-256
Tensile Strength @ Yield	17,500 psi	121 MPa	ASTM D-638
Tensile Elongation @ Break	7 %	7 %	ASTM D-638
Flexural Strength @ Yield	23,500 psi	162 MPa	ASTM D-790
Flexural Modulus	1,110,000 psi	7,659 MPa	ASTM D-790

Thermal Properties			
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DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	390 Deg. F	199 Deg. C	ASTM D-648
Melt Point	421 Deg. F	216 Deg. C	

All tests are performed on dry as molded ASTM test bars.

General Product Type Information
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DYN-N640GM, is also available with internal and external lubricants, UV stabilized and other modifications. Manufactured with recycled content. Further information and details are available upon request.

Processing Information			
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Temperatures		F	C
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Barrel	Rear	480 - 520	251 - 273
	Center	500 - 540	262 - 285
	Front	520 - 560	273 - 296
	Nozzle	520 - 560	273 - 296
	Mold	175 - 205	80 - 97

Drying	
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Type	Dehumidifier
Temperature	180°F
Time	2 - 4 hours
Max. % Moisture	0.2

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Dynamic Polymer Solutions disclaims any liability for loss or damage incurred in connection with the use of this product. Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.