

## Nylene® 615

Polymeric Resources Corporation (PRC) - Polyamide 6

### General Information

#### Product Description

- Nylon-6 extrusion grade suitable for coating and film co-extrusion applications
- Meets the requirements of FDA regulation for direct food contact
- Nylene 615 does not absorb food odors

#### General

Material Status	• Commercial: Active		
Availability	• North America		
Features	• Abrasion Resistant	• High Melt Stability	• Low Odor Transfer
	• Food Contact Acceptable	• High Melt Stability	
	• Grease Resistant	• High Toughness	
Uses	• Beverage Packaging	• Containers	• Food Packaging
	• Blown Film	• Fibers	• Multilayer Film
	• Cast Film	• Film	• Paper Coatings
Agency Ratings	• FDA 21 CFR 177.1500		
Forms	• Pellets		
Processing Method	• Film Extrusion		

### Properties <sup>1</sup>

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.13		ASTM D792
<b>Mechanical</b>			
Tensile Strength (Yield)	5510	psi	ASTM D638
Tensile Strength (Break)	8700	psi	ASTM D638
Tensile Elongation (Break)	290	%	ASTM D638
<b>Films</b>			
Secant Modulus - MD	94600	psi	ASTM D882
Elmendorf Tear Strength - MD	56	g	ASTM D1922
<b>Thermal</b>			
Peak Melting Temperature	428	°F	ASTM D3418

### Processing Information

	Nominal Value	Unit
<b>Extrusion</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Regrind	25	%
Cylinder Zone 1 Temp.	450 to 469	°F
Cylinder Zone 3 Temp.	469 to 489	°F
Cylinder Zone 5 Temp.	480 to 500	°F
Melt Temperature	480 to 500	°F
Die Temperature	480 to 500	°F

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

