

**Nylene® BS-640-A**

 Polymeric Resources Corporation (PRC) - *Polyamide 6*
**General Information**
**Product Description**

Compounding, General Grade, mid RV, unlubricated.

**General**

Material Status	• Commercial: Active
Availability	• North America
Features	• General Purpose      • Low Viscosity
Uses	• Compounding          • Fibers
Processing Method	• Compounding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Relative Viscosity <sup>2</sup>	2.60 to 2.82		
Moisture Content	0.12	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	11500	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	370000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	0.86	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	133	°F	ASTM D648
Additional Information	Nominal Value	Unit	Test Method
Methanol Extractables	1.0	%	

**Processing Information**

Extrusion	Nominal Value	Unit
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.

<sup>2</sup> 96% Sulphuric Acid @ 20°C
