



**Product Data Sheet &
General Processing Conditions**

**VLF 80211 EM HS
Nylon 6/6 (PA)
Long Glass Fiber
Easy Molding
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	60 %	60 %	
Specific Gravity	1.71	1.71	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0010 - 0.0030 in/in	0.10 - 0.30 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 256
unnotched 1/8 in (3.2 mm) section	30.0 ft-lbs/in	1602 J/m	D 4812
Tensile Strength	40000 psi	276 MPa	D 638
Tensile Elongation	1.5 - 2.5 %	1.5 - 2.5 %	D 638
Tensile Modulus	3.25 x 10 ⁶ psi	22409 MPa	D 638
Flexural Strength	60000 psi	414 MPa	D 790
Flexural Modulus	2.90 x 10 ⁶ psi	19996 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	470 °F	243 °C	D 648
@ 66 psi (455 kPa)	480 °F	249 °C	D 648
Ignition Resistance*			
Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	5000 - 18000 psi	34 - 124 MPa
Melt Temperature	520 - 570 °F	271 - 299 °C
Mold Temperature	150 - 255 °F	66 - 124 °C
Drying	2 - 4 hrs @ 175 °F	2 - 4 hrs @ 79 °C
Moisture Content	0.20 %	0.20 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 0.200 in (5 mm) minimum, in feed section, Screw diameter 0.65 - 0.80 in (16.5 - 20 mm) minimum, Compression section length 12 - 13 diameters, Check ring valve assembly - free flow type no restrictions, Nozzle orifice 0.250 in (6 mm) diameter. Feed throat from hopper to machine must have sufficient opening to prevent bridging of long pellet composition.