

INVISTA 1NA10 PA66 Resin

Properties (dry)		Value	Units	Method
Viscosity	RV in formic acid, nominal	48-65	—	ASTM D789
	VN at 0.5% in sulfuric acid, nominal	143-170	mL/g	ISO 307
	MFI at 275°C and 0.325 kg, g/10min	4.3	g/10min	ASTM D1238
Physical	Density	1.14	g/cm ³	ISO 1183
	Ash Content, %	0.0	%	ISO 3451-1
	TiO ₂ Content, %	0.0	%	ASTM E1621
	Moisture, %	<0.4	%	ISO 15512
Mechanical	Tensile Strength at Yield	83	MPa	ISO 527
	Elongation at Yield	4.4	%	ISO 527
	Elongation at Break	25	%	ISO 527
	Tensile Modulus	4000	MPa	ISO 527
	Flexural Modulus	3300	MPa	ISO 178
	Flexural Strength	130	MPa	ISO 178
	Notched Charpy at 23°C	6.2	kJ/m ²	ISO 179
	Unnotched Charpy at 23°C	42	kJ/m ²	ISO 179
	Notched Izod at 23°C	6.2	kJ/m ²	ISO 179
	Unnotched Izod at 23°C	64	kJ/m ²	ISO 180
Thermal	Melting Temperature, 10°C/min	265	°C	ISO 11357
	HDT at 0.45 MPa	235	°C	ISO 75
	HDT at 1.80 MPa	224	°C	ISO 75

Product Description

INVISTA 1NA10 is a general purpose, bright PA66 recycle-grade resin suitable for compounding, injection molding, and extrusion applications.

General Information

Material Status

Commercial: Active

Availability

North America, South America, Europe, Asia

Product Origin

North America

RoHS and REACH (SVHC)

No intentional additives or ingredients used in 1NA10 are among those in the European directive 2011/65/EC (RoHS), as amended.

No intentional additives or ingredients used in 1NA10 are SVHC substances according to REACH EC/1907/2006 (list as of 16-JAN-2020)

Process Guidelines for Molding

Drying Temperature	80 °C
Drying Time*	3 - 4 hours
Barrel Temperatures	
Rear	250 - 270 °C
Middle	270 - 290 °C
Front	270 - 290 °C
Nozzle	270 - 290 °C
Processing Temperature (melt)	280 - 295 °C
Mold Temperature	50 - 90 °C
Back Pressure**	2 - 10 bar
Vent Depth	0.007 - 0.04 mm
Cushion (range)	4 - 6 mm
Suggested Moisture (max)	0.20 wt%
Suggested Moisture (min)	0.10 wt%
Screw Speed	75 - 180 rpm

* Initial moisture below 0.25 wt%. Use dehumidified air.

** Melt pressure

INVISTA Nylon Polymer

Additional Information: Recycle@INVISTA.com

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Product Data Sheet Disclaimer

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