

Properties (dry)		Value	Units	Method
Viscosity	RV in formic acid, nominal	42	---	ASTM D789
	VN at 0.5% in sulfuric acid, nominal	138	mL/g	ISO 307
	RV at 1% in sulfuric acid, nominal	2.55	---	---
Physical	Density	1.14	g/cm <sup>3</sup>	ISO 1183
	Mold Shrinkage, 2.0 mm, Parallel	1.4	%	ISO 294-4
	Mold Shrinkage, 2.0 mm, Transverse	1.4	%	ISO 294-4
	Water Absorption - 24 hours	1.8	%	ISO 62
	Water Absorption - Equilibrium @ 50% RH		%	ISO 62
Mechanical	Tensile Strength at Yield	82	MPa	ISO 527
	Elongation at Yield	4.4	%	ISO 527
	Elongation at Break	33	%	ISO 527
	Tensile Modulus	2800	MPa	ISO 527
	Flexural Modulus	2800	MPa	ISO 178
	Flexural Strength	92	MPa	ISO 178
	Notched Charpy at 23°C	5.0	kJ/m <sup>2</sup>	ISO 179
	Notched Charpy at -30°C	4.3	kJ/m <sup>2</sup>	ISO 179
	Unnotched Charpy at 23°C	NB	kJ/m <sup>2</sup>	ISO 179
	Unnotched Charpy at -30°C	260	kJ/m <sup>2</sup>	ISO 179
	Notched Izod at 23°C	3.8	kJ/m <sup>2</sup>	ISO 180
Thermal	Melting Temperature, 10°C/min	258	°C	ISO 11357
	HDT at 0.45 MPa	191	°C	ISO 75
	HDT at 1.80 MPa	62	°C	ISO 75

**Product Description**

INVISTA U4201 NC01 is a general purpose, PA66 feedstock resin produced with low viscosity for higher flow. Primary use is compounding.

**General Information**
**Material Status**

Commercial: Active

**Availability**

North America, South America, Europe, Asia

**Features**

High flow for ease of processing, stable low viscosity, good whiteness

**RoHS**

No intentional additives or ingredients used in U4201 are among those in the European directive 2011/65/EC (RoHS), as amended.

**Process Guidelines for Molding**

Drying Temperature	80 °C
Drying Time*	8 - 12 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 0.5 wt%. Use dehumidified air.

\*\* Melt pressure

**INVISTA Nylon Polymer**

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**Product Data Sheet Disclaimer**

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