

Isocor™ 4007

Polyamide 6

Shakespeare Monofilaments and Specialty Polymers

Message:

Isocor™ 4007 is a high viscosity PA-6. This resin is specifically suited for applications requiring excellent abrasion, tensile and elongation properties. This resin can be processed using conventional techniques.

Typical applications for Isocor™ 4007 include:

profile extrusions

film extrusions

flexible tubing

fiber and filaments

General Information	
Features	Good flexibility Good wear resistance Viscosity, High
Uses	Films Pipe fittings Filament Fiber Profile
Forms	Particle
Processing Method	Film extrusion Profile extrusion molding Injection molding

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.10	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5	--	%	ASTM D955
Water Absorption (24 hr)	--	0.53	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1870	1640	MPa	ASTM D638
Tensile Strength	52.6	53.8	MPa	ASTM D638
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	140	140	J/m	ASTM D256
Dart Drop Impact	36.2	36.2	J	ASTM D3029
Thermal	Dry	Conditioned	Unit	Test Method
Glass Transition Temperature	120	--	°C	DSC
Melting Temperature	213	--	°C	DSC

Additional Information

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Color, ASTM D1003-97: 9.68 LColor, ASTM D1003-97: -4.64 aColor, ASTM D1003-97: -6.68 b

Injection	Dry	Unit
Dew Point	< -17.8	°C
Suggested Max Moisture	0.20	%
Hopper Temperature	79.4	°C
Rear Temperature	221 - 243	°C
Middle Temperature	227 - 260	°C
Front Temperature	238 - 271	°C
Nozzle Temperature	238 - 271	°C
Processing (Melt) Temp	238 - 271	°C
Mold Temperature	10.0 - 93.3	°C
Injection Pressure	3.45 - 13.8	MPa
Injection Rate	Fast	
Back Pressure	0.689	MPa

Extrusion	Dry	Unit
Suggested Max Moisture	0.10	%
Hopper Temperature	79.4	°C
Cylinder Zone 1 Temp.	254	°C
Cylinder Zone 2 Temp.	266	°C
Cylinder Zone 3 Temp.	271	°C
Cylinder Zone 4 Temp.	271	°C
Die Temperature	260	°C

Extrusion instructions

Flange: 510°F (266°C)Air Dew Point (max): 0°F (-18°C)Neck: 510°F (266°C)Head: 500°F (260°C)Pump: 500°F (260°C)L/D Ratio: 24 to 30:1Compression Ratio: 3.5:1Polymer @ Die: 450°F (232°C)Screw Pressure: 2000 psi

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