



Data Sheet

Dartek® Nylon Film

T-424 NA High Performance Industrial Film

Barrier Film

DARTEK® T-424 NA is a thin clear uniaxially oriented film made from nylon 6,6 designed for use as a release and carrier sheet.

Typical Applications

- High temperatures and interleaving sheet
- Fiberglass Reinforced Panel (FRP) manufacture

Key Features of T-424 NA

- High shrinkage. For greater wrap tension during high temperature curing processes by matching the shrinkage characteristics of working compounds
- Melt point of 510°F (265°C). For stability in prolonged high temperature curing processes.
- Good release characteristics. For ease of removal.

- Thin gauge. For improved cost-effectiveness and reduced waste
- Toughness. For high integrity in wrapping and handling
- Smooth uniform surface. For smooth finished products and reduced fibre prominence in FRP processes.

Availability

DARTEK® T-424 NA can be supplied in widths from 254mm to 2083mm (10 inches to 82 inches) in the gauges shown below. The “NA” surface is designed to facilitate total release upon process completion.

Mils	µm	in ² /lb	ft ² /lb	m ² /kg
0.60	15	40,800	283	58
0.75	19	32,700	227	46
1.00	25	24,500	170	35
1.25	32	19,600	1.3	28
1.50	38	16,300	113	23

Standard Roll Sizes

Metric

DIAMETER		kg/cm of width	Approximate Length Per Roll in Meters				
I.D.	O.D.		Gauge in Microns				
			15µ	19µ	25µ	32µ	38µ
152mm	457mm	1.59	9,260	7,410	5,560	4,440	3,700
152mm	546mm	2.38	13,850	11,080	8,310	6,650	5,540

Imperial

DIAMETER		lb/in of width	Approximate Length Per Roll in Feet				
I.D.	O.D.		Gauge in Mils				
			0.60	0.75	1.00	1.25	1.50
6"	18"	8.9	30,350	24,300	18,200	14,600	12,150
6"	21.5"	13.3	45,450	36,350	27,250	21,800	18,200

DARTEK® T-424 Typical Values

PROPERTY	TEST METHOD	UNITS	TYPICAL VALUES
GAUGE		mil	0.60
SPECIFIC GRAVITY	ASTM D-792	g/cc	1.14
GLOSS (20° GARDNER)	ASTM D-2457	PHOTOCELL MICROAMPS	150
TENSILE STRENGTH	ASTM D-882-64T (50% RH)	lb/in ²	MD 40,000 TD 9,000
TENSILE MODULUS	ASTM D-1530-58T (50% RH)	lb/in ²	MD 425,000 TD 375,000
ELONGATION	ASTM D-882-64T	%	MD 50 TD 250
TEAR STRENGTH (ELMENDORF-PROPAGATED)	ASTM D-1922-67	g/mil	MD 100 TD 100
TEAR STRENGTH (GRAVES-INITIAL)	ASTM D-1004	g/mil	MD 1,000 TD 700
IMPACT STRENGTH	ASTM D-1709-62T	g	100
DIMENSIONAL STABILITY	300°F 30 min.	%	MD 7.0 TD 2.0

Note: The values are typical for **DARTEK®** T-424 nylon film, and are not intended for use as limiting specifications. For additional information, please contact your Liqui-Box representative.

Moisture Sensitivity: **DARTEK®** nylon 6,6 film is a hydrophilic (moisture sensitive) material. It is preconditioned at the time of manufacture and shipped in a moisture-proof wrapping film to prevent changes in moisture content prior to use. To ensure optimum stability and performance, do not unwrap **DARTEK®** until it is to be used, and re-wrap it in the same film for extended storage.

The information contained in this bulletin is reliable to the best of our knowledge. But because we cannot control the conditions under which it may be used, Liqui-Box Canada cannot guarantee it or accept any obligation or liability arising from its use.

Selection of laminating adhesives for use with PVDC coated Dartek® films.

Experience has shown that on occasion and under certain conditions, solventless adhesive systems containing neopentyl glycol (NPG) when used to laminate PVDC coated Dartek® to other films, may result in an objectionable odor in the laminated film. Because of this experience, we are recommending both solvent-based and solventless laminating adhesives for use with PVDC coated Nylon be free of NPG. Your adhesive supplier should be able to recommend a NPG-FREE adhesive formulation.

For more information on Packaging Polymers:



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Customer Service: 800/263-2742
Fax: 905/666-7070

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