

Nylene® NX1440 HS

Polyamide 6

Custom Resins Group

Message:

Nylene NX1440 is a high viscosity, fast cycling molding resin. Crystallization initiators provide fast molding cycles through rapid melt set-up. Parts molded from NX1440 have better dimensional stability at moisture equilibrium than parts molded from conventional nylon. Nylene NX1440 provides for an excellent balance between stiffness and toughness.

General Information			
Additive	Heat Stabilizer		
	Nucleating Agent		
Features	Fast Molding Cycle		
	Good Dimensional Stability		
	Good Stiffness		
	Good Thermal Stability		
	Good Toughness		
	Heat Stabilized		
	High Heat Resistance		
	High Viscosity		
	Homopolymer		
	Nucleated		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.90	%	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	75.2	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	25	%	ASTM D638
Flexural Modulus (23°C)	2900	MPa	ASTM D790
Flexural Strength (Yield, 23°C)	114	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	43	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	82.2	°C	ASTM D648

Melting Temperature	216	°C
Injection	Nominal Value	Unit
Drying Temperature	65.6 to 82.2	°C
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	4.0	hr
Suggested Max Moisture	0.20	%
Suggested Shot Size	25 to 75	%
Suggested Max Regrind	25	%
Rear Temperature	221 to 246	°C
Middle Temperature	227 to 260	°C
Front Temperature	238 to 271	°C
Nozzle Temperature	238 to 271	°C
Processing (Melt) Temp	238 to 271	°C
Mold Temperature	48.9 to 93.3	°C
Injection Pressure	27.6 to 82.7	MPa
Injection Rate	Fast	
Holding Pressure	20.7 to 62.1	MPa
Back Pressure	0.00 to 0.345	MPa

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