

ColorFast® NY1GF330

Polyamide 6
LTL Color Compounders, Inc.

Message:
33% glass-filled nylon 6

General Information			
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.15 to 0.70	%	ASTM D955
Water Absorption (24 hr)	1.9	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	138	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	2.0	%	
Break	3.0	%	
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	221	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	221	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	30 to 60	%	
Rear Temperature	260 to 293	°C	
Middle Temperature	266 to 293	°C	
Front Temperature	266 to 293	°C	
Nozzle Temperature	260 to 288	°C	
Processing (Melt) Temp	279 to 304	°C	
Mold Temperature	37.8 to 93.3	°C	
Back Pressure	0.345 to 0.689	MPa	

Screw Speed	60 to 120	rpm
Vent Depth	0.038 to 0.076	mm

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