

ColorFast® NY1

Polyamide 6

LTL Color Compounders, Inc.

Message:

Injection molding nylon 6, with or without lube

General Information			
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5 to 2.0	%	ASTM D955
Water Absorption (24 hr)	1.7	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	79.3	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield	15	%	
Break	70	%	
Flexural Modulus ³	2780	MPa	ASTM D790
Flexural Strength ⁴	118	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)	68.3	°C	ASTM D648
Injection	Nominal Value	Unit	Test Method
Drying Temperature	79.4	°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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NOTE

1.	51 mm/min
2.	51 mm/min
3.	51 mm/min
4.	51 mm/min

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