

NYCOA Polyamide 6215 HS

Polyamide 612

Nycoa (Nylon Corporation of America)

Message:

NYCOA 6215 HS is a 15% glass fiber reinforced, impact modified, Nylon 6/12 that offers an excellent balance of stiffness and impact strength. This grade features excellent dimensional stability with low moisture absorption compared to other glass filled Nylons.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Impact modifier		
Features	Good dimensional stability		
	Impact modification		
	Low hygroscopicity		
	Rigid, good		
	Impact resistance, good		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Water Absorption (24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	101	MPa	ASTM D638
Tensile Elongation ² (Break)	10	%	ASTM D638
Flexural Modulus ³	3600	MPa	ASTM D790
Flexural Strength ⁴	120	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (6.35 mm)	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	217	°C	DSC
Additional Information			
The value listed as Melting Point DSC, was tested in accordance with ASTM D789.			
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 82.2	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	227 - 238	°C	
Middle Temperature	238 - 249	°C	
Front Temperature	243 - 260	°C	
Nozzle Temperature	243 - 260	°C	

Processing (Melt) Temp	243 - 260	°C
Mold Temperature	65.6 - 76.7	°C
Injection Rate	Fast	
Back Pressure	0.138 - 0.517	MPa
Cushion	1.59 - 6.35	mm
Screw L/D Ratio	16.0:1.0	
Screw Compression Ratio	3.0:1.0	

NOTE

- | | |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 50 mm/min |
| 4. | 50 mm/min |

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