

NYCOA Polyamide 2025

Polyamide 6

Nycoa (Nylon Corporation of America)

Message:

NYCOA 2025 is a medium viscosity Nylon 6 resin that contains special additives for improved screw retraction and mold release. It is suitable for injection molding and extrusion processing.

NYCOA 2025 provides injection molded parts with greater toughness and durability than standard molding grades, without sacrificing significant cycle time. It was specifically developed to manufacture sport shoe cleats. Other applications include sporting

NYCOA 2025 is also well suited for extrusion coating or jacketing applications. It provides a high gloss surface finish and improved line speeds.

General Information	
Additive	demoulding
Features	Highlight
	Fast molding cycle
	Durability
	Good toughness
	Good demoulding performance
	Excellent appearance
	Medium viscosity
Uses	Highlight applications
	Sporting goods
	Footwear
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	1.2	%	ASTM D955
Transverse flow	1.5	%	ASTM D955
Water Absorption (24 hr)	1.7	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	80.0	MPa	ASTM D638
Tensile Elongation ² (Break)	80	%	ASTM D638
Flexural Modulus ³	2450	MPa	ASTM D790

Flexural Strength ⁴	93.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (6.35 mm)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	185	°C	ASTM D648
1.8 MPa, not annealed	67.8	°C	ASTM D648
Melting Temperature	221	°C	
Additional Information			
The value listed as Melting Point 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	221 - 241	°C	
Middle Temperature	235 - 252	°C	
Front Temperature	246 - 260	°C	
Nozzle Temperature	254 - 266	°C	
Processing (Melt) Temp	249 - 266	°C	
Mold Temperature	76.7 - 87.8	°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.	51 mm/min		
2.	51 mm/min		
3.	51 mm/min		
4.	51 mm/min		

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