

NYCOA Polyamide 5025 FR

Polyamide 66

Nycoa (Nylon Corporation of America)

Message:

NYCOA 5025 FR is a 25% glass fiber reinforced, flame retardant Nylon 66 resin used for injection molding.
NYCOA 5025 FR is approved by Underwriters Laboratories as a UL 94 VO material at .75mm thickness.
NYCOA 5025 FR is available in UV stable, custom colors, and impact modified grades. It also has excellent chemical resistance to greases, oils, and other hydrocarbons.
Typical applications include electrical coil bobbins, switches, connectors, relay housings, and automotive ashtrays.

General Information			
UL YellowCard	E86478-252068		
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Features	Good chemical resistance		
	Hydrocarbon resistance		
	Oil resistance		
	Grease resistance		
	Flame retardancy		
Uses	Electrical components		
	Switch		
	Connector		
	Car interior parts		
	Shell		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.20	%	ASTM D955
Transverse flow	0.70	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	135	MPa	ASTM D638
Tensile Elongation ² (Break)	4.0	%	ASTM D638
Flexural Modulus ³	8000	MPa	ASTM D790
Flexural Strength ⁴	221	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (6.35 mm)	96	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	256	°C	ASTM D648
1.8 MPa, not annealed	242	°C	ASTM D648
Melting Temperature	260	°C	DSC
Flammability	Nominal Value		Test Method
Flame Rating (0.750 mm)	V-0		UL 94

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	266 - 282	°C
Middle Temperature	277 - 293	°C
Front Temperature	288 - 304	°C
Nozzle Temperature	282 - 302	°C
Processing (Melt) Temp	288 - 304	°C
Mold Temperature	76.7 - 87.8	°C
Injection Rate	Fast	
Back Pressure	0.138 - 0.345	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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