

NYCOA Polyamide ASN 27 250 KNF

Polyamide 6

Nycoa (Nylon Corporation of America)

Message:

NYCOA ASN 27/250 KNF is a 25% glass fiber reinforced, heat stabilized, lubricated Nylon 6 resin used for injection molding. This material is specifically engineered for applications requiring high stiffness, toughness, dimensional stability, and a greater

NYCOA ASN 27/250 KNF is available in UV stable, custom colors, and impact modified grades. It also has excellent chemical resistance to greases, oils, and other hydrocarbons.

NYCOA ASN 27/250 KNF is suitable for injection molding and can be found in applications such as power tool housings and lawn & garden components.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Additive	heat stabilizer		
	Lubricant		
Features	Good dimensional stability		
	Rigidity, high		
	Good chemical resistance		
	Hydrocarbon resistance		
	Oil resistance		
	Grease resistance		
	Thermal Stability		
	Good toughness		
	Lubrication		
Uses	Lawn and Garden Equipment		
	Power/other tools		
	Shell		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.40	%	ASTM D955
Transverse flow	0.60	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	8050	MPa	ASTM D638

Tensile Strength ²	150	MPa	ASTM D638
Tensile Elongation ³ (Break)	3.0	%	ASTM D638
Flexural Modulus ⁴	6930	MPa	ASTM D790
Flexural Strength ⁵	235	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (6.35 mm)	43	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	218	°C	ASTM D648
1.8 MPa, not annealed	204	°C	ASTM D648
Melting Temperature	220	°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	232 - 271	°C
Middle Temperature	243 - 282	°C
Front Temperature	254 - 291	°C
Nozzle Temperature	252 - 291	°C
Processing (Melt) Temp	254 - 291	°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
5.	51 mm/min

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