

ColorFast® HGA1500

Americhem - Polyamide 6 Alloy

General Information

Product Description

HGA1500 is an injection molding grade of nylon 6 alloy with excellent weatherability, chemical resistance, and scratch resistance. It is suitable for applications that require a high gloss and surface finish.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Excellent Colorability		
Uses	• Closures • Consumer Applications • Engineering Parts	• Household Goods • Housings • Industrial Applications	• Industrial Parts • Outdoor Applications
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.05		ASTM D792
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	9.0E-3 to 0.012	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	6400	psi	ASTM D638
Tensile Strength ² (Break)	6000	psi	ASTM D638
Tensile Elongation ² (Yield)	7.0	%	ASTM D638
Tensile Elongation ² (Break)	200	%	ASTM D638
Flexural Modulus ²	175000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	16	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	140	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	140 to 149	°F
Drying Time	6.0 to 8.0	hr
Drying Time, Maximum	24	hr
Suggested Shot Size	30 to 70	%
Rear Temperature	465	°F
Middle Temperature	465	°F
Front Temperature	465	°F
Nozzle Temperature	480	°F
Processing (Melt) Temp	450 to 495	°F
Mold Temperature	125 to 135	°F
Back Pressure	50.0 to 100	psi
Vent Depth	1.0E-3 to 1.5E-3	in

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

