

ColorFast® PA6-1000

Americhem - Polyamide 6

General Information

Product Description

ColorFast PA6-1000 is a general-purpose, injection molding grade of PA6.

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	1.13		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.015	in/in	ASTM D955
Water Absorption (24 hr)	1.7	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	11500	psi	ASTM D638
Tensile Strength ² (Break)	10900	psi	ASTM D638
Tensile Elongation ² (Yield)	4.0	%	ASTM D638
Tensile Elongation ² (Break)	70	%	ASTM D638
Flexural Modulus ²	410000	psi	ASTM D790
Flexural Strength ²	16000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.0	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	155	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	30 to 60	%
Rear Temperature	470 to 510	°F
Middle Temperature	470 to 520	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	510 to 530	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	5.0E-4 to 1.0E-3	in

