

Processing Data

Grade NY1GF130

13 % glass-filled nylon 6

| Injection Molding Parameters | Nominal Values (English) |
|-------------------------------------|---------------------------------|
| Drying Temperature | 180 °F |
| Drying Time | 2-4 Hours |
| Drying Time, Maximum | 8 Hours |
| Melt Temperature | 535-580 °F |
| Nozzle Temperature | 500-550 °F |
| Front Temperature | 510-560 °F |
| Middle Temperature | 510-560 °F |
| Rear Temperature | 500-560 °F |
| Mold Temperature | 100-200 °F |
| Back Pressure | 50-100 psi |
| Screw Speed | 60-120 rpm |
| Suggested Shot Size | 30-60 % |
| Vent Depth | .0015-.003 in |

The values shown are typical values that have been obtained using test bars molded from laboratory samples and are not intended for specification purposes. These values are for natural colors only. Addition of pigments may alter some values. Inasmuch as LTL Color Compounders has no control over the use to which others may put the material, it does not guarantee that the same results as those described herein will be obtained. Each user of the material should make his own test to determine the material's suitability for his own particular use. Statements concerning possible or suggested uses of the materials described herein are not to be construed as constituting a license under any LTL Color Compounders patent covering such use or as recommendations for use of such materials in the infringement of any patent. These are developmental products with estimated physical property profiles. Actual values will need to be determined upon production of material.