



# Hylon® N1033L

Ravago Manufacturing Americas, LLC - Polyamide 66

Thursday, August 19, 2010

## General Information

### General

Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber Reinforcement, 33% Filler by Weight	
Additive	• Lubricant	
Features	• Lubricated	
RoHS Compliance	• RoHS Compliant	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

## ASTM & ISO Properties <sup>1</sup>

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.38	--		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.0030 to 0.0050	--	in/in	ASTM D955
Water Absorption (24 hr)	0.70	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Yield, 73°F)	28000	20000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.0	3.0	%	ASTM D638
Flexural Modulus (73°F)	1.35E+6	900000	psi	ASTM D790
Flexural Strength (73°F)	38000	28000	psi	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (73°F)	2.20	2.50	ft-lb/in	ASTM D256
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	98	85		ASTM D785
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	480	475	°F	ASTM D648
CLTE - Flow	0.000013	--	in/in/°F	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+15	--	ohm-cm	ASTM D257
Dielectric Strength	520	--	V/mil	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating - UL				UL 94
0.0295 in, NC	HB	HB		
0.0590 in, BK	HB	--		
0.0590 in, NC	HB	--		
0.0591 in, BK	--	HB		
0.0591 in, NC	--	HB		
0.118 in, BK	HB	HB		
0.118 in, NC	HB	HB		

### Additional Information

Dry	Dielectric Strength, ASTM D149, Short Time: 520 V/mil
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The information presented on this data sheet was acquired by IDES from the producer of the material. IDES makes substantial efforts to assure the accuracy of this data. However, IDES assumes no responsibility for the data values and strongly encourages that upon final material selection, data points are validated with the material supplier.

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	165	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	540 to 570	°F
Mold Temperature	150 to 210	°F
Back Pressure	20.0 to 60.0	psi
Screw Speed	40 to 120	rpm

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.