

NYLENE® 5233-04 HS

PA6-GF33

Polymeric Resources Corporation

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| ASTM Data | | | |
| Mold Shrinkage, MD | 0.006 | mm/mm | ASTM D 955 |

| Mechanical properties | Value | Unit | Test Standard |
|------------------------------|--------------|-------------|----------------------|
| ASTM Data | | | |
| Tensile Strength | 131 | MPa | ASTM D 638 |
| Elongation at Break | 20 | % | ASTM D 638 |
| Flexural Modulus | 7239 | MPa | ASTM D 790 |
| Izod Impact notched, 1/8 in | 80.1 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|---------------------------|--------------|-------------|----------------------|
| ASTM Data | | | |
| DTUL @ 264 psi | 193 | °C | ASTM D 648 |

| Other properties | Value | Unit | Test Standard |
|-------------------------|--------------|-------------------|----------------------|
| Density | 1370 | kg/m ³ | ASTM D 792 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|--|------------------|-------------|----------------------|
| Pre-drying - Temperature | 66 - 82 | °C | - |
| Pre-drying - Time | 2 - 4 | h | - |
| Processing humidity | ≤0.2 | % | - |
| Melt temperature | 288 - 302 | °C | - |
| Mold temperature | 82 - 93 | °C | - |
| Zone 1 | 249 - 277 | °C | - |
| Zone 2 | 260 - 288 | °C | - |
| Zone 3 | 271 - 299 | °C | - |
| Nozzle temperature | 271 - 299 | °C | - |
| Injection pressure | 8 - 18 | MPa | - |
| Back pressure | 0 - 50 | MPa | - |
| Holding pressure | 6 - 15 | MPa | - |
| Maximum residence time | 6 | min | - |

Characteristics**Processing**

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Applications

Automotive, Sports Equipment

Regional Availability

North America