

NYLENE® 5135 HS

PA66-GF35

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.03	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	155	MPa	ISO 527
Flexural modulus, 23°C	7630	MPa	ISO 178
Charpy impact strength, +23°C	106	kJ/m ²	ISO 179/1eU

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	255	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	237	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	65 - 82	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	287 - 316	°C	-
Mold temperature	82 - 93	°C	-
Zone 1	260 - 293	°C	-
Zone 2	277 - 299	°C	-
Zone 3	282 - 310	°C	-
Nozzle temperature	279 - 307	°C	-
Injection pressure	5 - 15	MPa	-
Back pressure	0 - 50	MPa	-
Holding pressure	4 - 12	MPa	-
Maximum residence time	6	min	-

Characteristics**Processing**

Injection Molding

Additives

Lubricants

Special Characteristics

Heat stabilized or stable to heat

Chemical Resistance

General Chemical Resistance, Oil Resistance

Applications

Automotive, Electrical and Electronical, General Purpose

Regional Availability

North America