

NYLENE® 4214-33 HS

PA6-GF33

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	138	MPa	ASTM D 638
Flexural Modulus	7584	MPa	ASTM D 790
Izod Impact notched, 1/8 in	176	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	210	°C	ASTM D 648
Melting Temperature	216	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	1360	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

Applications

Automotive, General Purpose

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Regional Availability

North America