

**NYLENE® 5133 HS**

PA66-GF33

Polymeric Resources Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	10000	MPa	ISO 527
Tensile Strength	190	MPa	ISO 527
Flexural modulus, 23°C	9300	MPa	ISO 178
Charpy notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	263	°C	ISO 11357-1/-3
<b>Other properties</b>			
Density	1370	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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

**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