Vydyne® R633H05

PA66/6-GF33 Ascend

Product Texts

Vydyne R633H05 is 33% glass-fiber reinforced PA66/6 copolymer resin for superior surface appearance. Available in black, this injection-molding grade resin is lubricated for machine feed and mold release.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
[C] Molding shrinkage, parallel	**0.4 / ***	%	ISO 294-4, 2577
[C] Molding shrinkage, normal	**0.9 / ***	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**10800 / 8000**	MPa	ISO 527
[C] Stress at break	**184 / 130**	MPa	ISO 527
[C] Strain at break	**4 / 6**	%	ISO 527
Flexural modulus, 23°C	**8800 / 6800**	MPa	ISO 178
Flexural strength	**255 / 195**	MPa	ISO 178
[C] Charpy impact strength, +23°C	**51 / 92**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**44 / 91**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**12 / 25**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**11 / 15**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**13 / 22**	kJ/m²	ISO 180/1A
Izod notched impact strength	**12 / 19**	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**233 / ***	°C	ISO 11357-1/-3
[C] Temp. of deflection under load, 1.80 MPa	**220 / ***	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**230 / ***	°C	ISO 75-1/-2
[C] Coeff. of linear therm. expansion, parallel	**15 / ***	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**100 / ***	E-6/K	ISO 11359-1/-2
[C] Burning Behav. at 1.5 mm nom. thickn.	**HB / ***	class	IEC 60695-11-10
Thickness tested	**1.5 / ***	mm	-
[C] Burning Behav. at thickness h	**HB / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**0.75**	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Comparative tracking index	**325 / -**	-	IEC 60112
ASTM Data			
Arc Resistance	**150 / -**	s	ASTM D 495

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**1.3 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**2.3 / ***	%	Sim. to ISO 62
[C] Density	**1390 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**4**	h	-

Melt temperature	**285 - 305**	°C	-
Mold temperature	**65 - 95**	°C	-
Zone 1	**280 - 310**	°C	-
Zone 2	**280 - 310**	°C	-
Zone 3	**280 - 310**	°C	-
Nozzle temperature	**280 - 310**	°C	-

Characteristics

Processing
Injection Molding

Delivery form
Pellets, Black

Additives
Lubricants, Release agent

Special Characteristics
Heat stabilized or stable to heat

Features
Copolymer

Applications
Automotive

Regional Availability
North America, Europe, Asia Pacific