

## BASF Capron® HPN 9333G Impact Modified, 33% Glass-Filled Nylon 6 (Dry) (discontinued \*\*)

Category : Polymer , Thermoplastic , Nylon , Nylon 6 , Nylon 6, Glass Filled, Impact Grade

### Material Notes:

Capron HPN 9333G is a 33% glass reinforced, impact modified polyamide 6 injection molding compound combining exceptional strength, stiffness and high temperature performance with excellent surface aesthetics. It is one of the High Productivity Nylon series products, offering the performance characteristics of a premium glass fiber reinforced polyamide while reducing cycle time and improving surface appearance. Capron HPN 9333G HS is generally recommended for applications such as power tool housings and under the hood components. Data provided by Allied Signal. Processing: Max. water content 0.12%. Product is supplied in sealed containers and drying is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 85°C (185 °F). Is recommended. Drying time is dependent on moisture level. Melt Temperature: 270-295 degC (518-563 degF). Mold Temperature: 80-95 degC (176-203 degF). Injection and Packing Pressure: 35-125 bar (500-1500psi) This product can be processed over a wide range of mold temperatures; however, for applications where aesthetics critical, a mold surface temperature of 80-95 degC (176-203 degF) is required. Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off. Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. A maximum of 3.5 bar (50 psi) is recommended to minimize glass fiber breakage. Fast fill rates are recommended to insure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate. Capron® is no longer a part of the BASF standard line. The BASF nylon products have been consolidated in the Ultramid ® line.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_BASF-Capron-HPN-9333G-Impact-Modified-33-Glass-Filled-Nylon-6-Dry-nbspdiscontinued-.php](http://www.lookpolymers.com/polymer_BASF-Capron-HPN-9333G-Impact-Modified-33-Glass-Filled-Nylon-6-Dry-nbspdiscontinued-.php)

Physical Properties	Metric	English	Comments
Density	1.34 g/cc	0.0484 lb/in <sup>3</sup>	ISO data
Water Absorption	0.90 %	0.90 %	24 hrs; ISO data
Moisture Absorption at Equilibrium	1.5 %	1.5 %	50% RH; 23°C; ISO data
Water Absorption at Saturation	5.4 %	5.4 %	in water; 23°C; ISO data
Linear Mold Shrinkage	0.0020 cm/cm	0.0020 in/in	ISO data
	0.0030 cm/cm	0.0030 in/in	ASTM data MD
Linear Mold Shrinkage, Transverse	0.0090 cm/cm	0.0090 in/in	ISO Data

Mechanical Properties	Metric	English	Comments
Tensile Strength, Ultimate	150 MPa	21800 psi	ASTM data at 5 mm/min.
	152 MPa	22000 psi	ISO value at 5mm/min.
Elongation at Break	3.5 %	3.5 %	ASTM, 5 mm/min

Mechanical Properties	Metric	English	Comments
Tensile Modulus	9.41 GPa	1360 ksi	same value from ASTM and ISO test.
Flexural Yield Strength	235 MPa	34100 psi	ASTM Data
Flexural Modulus	8.00 GPa	1160 ksi	ASTM Data
Poissons Ratio	0.35	0.35	ISO data
Shear Modulus	3.50 GPa	508 ksi	calculated
Charpy Impact, Notched	1.90 J/cm <sup>2</sup>	9.04 ft-lb/in <sup>2</sup>	ISO Data
	1.40 J/cm <sup>2</sup> @Temperature -30.0 °C	6.66 ft-lb/in <sup>2</sup> @Temperature -22.0 °F	ISO data

Thermal Properties	Metric	English	Comments
CTE, linear, Parallel to Flow	24.0 µm/m-°C @Temperature 20.0 °C	13.3 µin/in-°F @Temperature 68.0 °F	ISO data
CTE, linear, Transverse to Flow	84.0 µm/m-°C @Temperature 20.0 °C	46.7 µin/in-°F @Temperature 68.0 °F	ISO data
Melting Point	220 °C	428 °F	ASTM and ISO test
Deflection Temperature at 0.46 MPa (66 psi)	219 °C	426 °F	ISO data
Deflection Temperature at 1.8 MPa (264 psi)	205 °C	401 °F	ISO data
	210 °C	410 °F	ASTM Data
Flammability, UL94	HB @Thickness 0.800 mm	HB @Thickness 0.0315 in	
	HB @Thickness 3.00 mm	HB @Thickness 0.118 in	

Electrical Properties	Metric	English	Comments
Electrical Resistivity	>= 1.00e+15 ohm-cm	>= 1.00e+15 ohm-cm	ISO data

Processing Properties	Metric	English	Comments
Processing Temperature	275 °C	527 °F	See Materials Notes
Mold Temperature	95.0 °C	203 °F	See Materials Notes

Processing Properties

Metric

English

Comments is Notes

## Contact Songhan Plastic Technology Co.,Ltd.

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