

Ravago Manufacturing Americas Hylon® N1000HL Nylon 6/6

Category : Polymer , Thermoplastic , Nylon , Nylon 66 , Nylon 66, Heat Stabilized

Material Notes:

Available in North America Additive: Heat Stabilizer and Lubricant Features: Heat Stabilized and Lubricated RoHS Compliant Auto Specifications: FORD WSK-M4D648-A Color: Black Form: Pellets Processing Method: Injection Molding Properties are for dry polymer unless noted. Information provided by Ravago.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylon-N1000HL-Nylon-66.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.14 g/cc	1.14 g/cc	ASTM D792
Water Absorption	1.3 %	1.3 %	ASTM D570
	@Time 86400 sec	@Time 24.0 hour	
Linear Mold Shrinkage, Flow	0.014 - 0.019 cm/cm	0.014 - 0.019 in/in	ASTM D955
	@Thickness 3.17 mm	@Thickness 0.125 in	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell M	60	60	Conditioned; ASTM D785
	85	85	ASTM D785
Tensile Strength at Break	65.5 MPa	9500 psi	Conditioned; D638
	82.7 MPa	12000 psi	D638
Elongation at Break	30 %	30 %	ASTM D638
	200 %	200 %	Conditioned; ASTM D638
Flexural Strength	40.7 MPa	5900 psi	Conditioned; ASTM D790
	114 MPa	16500 psi	ASTM D790
Flexural Modulus	1.31 GPa	190 ksi	Conditioned; ASTM D790
	3.03 GPa	440 ksi	ASTM D790
Izod Impact, Notched	0.534 J/cm	1.00 ft-lb/in	ASTM D256
	1.33 J/cm	2.50 ft-lb/in	Conditioned; ASTM D256

Thermal Properties	Metric	English	Comments
CTE, linear, Parallel to Flow	82.8 $\mu\text{m}/\text{m}\cdot^{\circ}\text{C}$	46.0 $\mu\text{in}/\text{in}\cdot^{\circ}\text{F}$	ASTM D696

Thermal Properties	Metric	English	Comments
Tensile Strength at 0.46 MPa (66 psi)	238 °C	460 °F	Unannealed; ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	71.1 °C	160 °F	Unannealed, Conditioned; ASTM D648
	87.8 °C	190 °F	Unannealed; ASTM D648
Flammability, UL94	V-2	V-2	Conditioned
	@Thickness 1.50 mm	@Thickness 0.0591 in	
	V-2	V-2	
	@Thickness 1.50 mm	@Thickness 0.0591 in	

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+13 ohm-cm	1.00e+13 ohm-cm	Conditioned; ASTM D257
	1.00e+15 ohm-cm	1.00e+15 ohm-cm	ASTM D257
Dielectric Constant	3.7	3.7	ASTM D150
	@Frequency 100 Hz	@Frequency 100 Hz	
	6.0	6.0	Conditioned; ASTM D150
	@Frequency 100 Hz	@Frequency 100 Hz	
Dielectric Strength	21.7 kV/mm	550 kV/in	Conditioned; ASTM D149
	22.8 kV/mm	580 kV/in	Method A (Short-time); ASTM D149

Processing Properties	Metric	English	Comments
Melt Temperature	271 - 293 °C	520 - 560 °F	
Mold Temperature	48.9 - 93.3 °C	120 - 200 °F	
Drying Temperature	73.9 °C	165 °F	
	@Time 7200 - 14400 sec	@Time 2.00 - 4.00 hour	
Moisture Content	<= 0.20 %	<= 0.20 %	Suggested Maximum
Back Pressure	0.345 - 0.689 MPa	50.0 - 100 psi	
Screw Speed	40 - 140 rpm	40 - 140 rpm	

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