

Nylene® 132 HS

TECHNICAL DATASHEET

TDS Ref # 750 Reviewed: 4/24/2018

DESCRIPTION

- Nylene 132 HS is a low viscosity, heat stabilized nylon 6,6 molding resin.
- Suitable for a variety of applications where heat, chemical, and wear resistance are required.
- Has the high heat and chemical resistance characteristic of nylon 6/6 materials, combined with high flow and easy molding.
- This product is UL recognized.

| PROPERTIES | TEST METHOD | UNIT | VALUE |
|------------------------------|-------------|--------------------|-----------------|
| PHYSICAL PROPERTIES | | | |
| Mold Shrinkage | n/a | in/in | 0.013 |
| Specific Gravity | D792 | n/a | 1.14 |
| MECHANICAL PROPERTIES | | | |
| Elongation @ Break | (%) | psi (MPa) | 50 |
| Flexural Modulus | D790 | psi (MPa) | 415,000 (2,860) |
| Notched Izod @ 23°C | D256 | ft. lb./ in. (J/m) | 1.0 (53) |
| Tensile Strength | D638 | psi (MPa) | 12,000 (83) |
| THERMAL PROPERTIES | | | |
| DTUL @ 1820 kPa | D648 | °F (°C) | 194 (90) |
| Melt Point | D3418 | °F (°C) | 490 (254) |

NOTES

- Testing conducted on dry-as-molded specimens at 73°F (22.8°C)

PROCESSING CONSIDERATIONS: PA 6/6 UNREINFORCED

| | | |
|----------|-------------|----------------------|
| °F (°C) | Rear Zone | 500-540 (260-282) |
| | Center Zone | 520-560 (271-293) |
| | Front Zone | 540-580 (282-304) |
| | Nozzel | 535-575 (279-301) |
| | Melt Temp. | 540-580 (282-304) |
| PRESSURE | Injection | 7-15,000 |
| | Hold | 5-12,000 |
| | Back | 0-50 |

Melt Temperature: Nylene® PA6/6 melts at 490 °F (254°C), actual melt temperatures of 540-600 (282-316°C) are permissible, depending on residence time and shot size.

Mold Temperature: 120-200 °F (49-93°C), highly filled grades require 180-200 °F (82-93°C) to obtain the best overall surface appearance, higher temperatures will increase crystallinity.

Residence Time: should not exceed 6 minutes if possible, less with higher melt temperatures.

Shot Size: should be between 25-75% of barrel capacity.

Fill Rate: fast fill rates are suggested for best surface appearance.

Regrind Level: typically no more than 25% is recommended, with higher levels possible for unfilled grades depending on the end use requirements. Make certain regrind is properly dried to virgin moisture levels.

Drying Temperature: 150-180 °F (65-182°C) for 2-4 hours, Nylene® PA6/6 should be dried to less than 0.20% moisture for optimum performance. Drying longer than 4 hours or at higher temperatures may cause oxidation of the polymer or remove essential volatiles.

CHARACTERISTICS

Resin Type: Nylon 6/6

Product Characteristics:

Unreinforced, Heat Stabilized, Low RV

INJECTION MOLDING PROCESSING

Prime Grade

MARKETS USED

- Automotive Applications
- General Applications
- Electrical Applications
- Tool & Appliance

APPLICATIONS

- Bushing
- Encapsulation
- Exterior/Interior Car Parts
- Power Tool Housing
- Seat Adjuster Levers
- Stove Knobs

APPROVALS

- UL 94: V-2

AUTOMOTIVE SPECIFICATION

- ESF-M4D82-A
- MS-DB41 CPN 1076
- MS-DB41 CPN 3324
- ASTM D4066 PA0121

DISCLAIMER

The data set forth herein has been carefully compiled by Nylene in our laboratories. Values shown are typical properties and not specifications. Since processing variables will affect properties, the reproducibility of our data in a customer's testing facility is not guaranteed. There is no warranty of any kind, either expressed or implied, applicable to the use of this information, and the user assumes all risk and liability in connection therewith.



Headquarters and Facility:

55 Haul Road, Wayne, NJ 07470
P: 973-694-4141 | F: 973-694-3549

North American Sales Office:

31700 Telegraph Rd. Suite 235, MI 48025
P: 248-377-6769 | F: 248-377-3845

Nylene Custom Resins Facility:

1421 Hwy 136 W. Henderson, KY 42420
P: 270-826-7641 | TF: 800-626-7050

Nylene Canada Facility

200 McNab Street, Arnprior ON, K7S 3P2
P: 613-623-3191 | TF: 800-267-7394

For a complete listing of our global offices, visit:

www.nylene.com/contactus

www.nylene.com | info@nylene.com

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