

Nylene® 733

TECHNICAL DATASHEET

TDS Ref # 155 Reviewed: 5/25/2017

DESCRIPTION

- Highly impact modified nylon 6 suitable for both molding and extrusion
- Parts molded from 733 have excellent impact strength right out of the mold without post conditioning.

PROPERTIES	TEST METHOD	UNIT	VALUE
PHYSICAL PROPERTIES			
Mold Shrinkage	n/a	in/in	0.014
Specific Gravity	D792	n/a	1.08
MECHANICAL PROPERTIES			
Elongation @ Break	D638	[%]	200
Flexural Modulus	D790	psi (MPa)	261,000 (1,800)
Notched Izod @ 23°C	D256	ftlb/in (J/m)	No Break
Notched Izod @ -40°C	D256	ft-lb/in (J/m)	3.0 (160)
Tensile Strength	D638	psi (MPa)	7,250 (50)
THERMAL PROPERTIES			
DTUL @ 1820 kPa	D648	°F (°C)	118 (48)
Melt Point	D3418	°F (°C)	424 (218)

NOTES

- Testing conducted on dry-as-molded specimens at 73°F (22.8°C)
- Cylinder temperatures should be in the 475 - 525 °F range.

PROCESSING CONSIDERATIONS: PA 6 IMPACT MODIFIED

°F (°C)	Rear Zone	440-500 (227-260)	Melt Temperature: Melt Temperature: Nylene® PA6 melts at 428°F, (220°C) actual melt temperatures of 440-560°F (227-293°C) are permissible, depending on residence time and shot size.
	Center Zone	460-520 (238-271)	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.
	Front Zone	480-540 (249-282)	Residence Time: should not exceed 6 minutes if possible, less with higher melt temperatures
	Nozzel	480-540 (249-282)	Shot Size: should be between 25-75% of barrel capacity.
	Melt Temp.	480-540 (249-282)	Fill Rate: fast fill rates are suggested for best surface appearance.
PRESSURE	Injection	7-15,000	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.
	Hold	5-12,000	Drying Temperature: 150-180°F (66-82°C) for 2-4 hours, Nylene® PA6 should be dried to less than 0.20% moisture for optimum performance. Drying longer than 4 hours or at higher temperatures may cause discoloration of the polymer or adversely affect important physical properties.
	Back	0-50	

CHARACTERISTICS

Resin Type: Nylon 6
Product Characteristics:
Impact Modified

INJECTION MOLDING PROCESSING

Prime Grade

FEATURES

- High flexibility
- High impact resistance
- No break - Notched Izod at 23 °C
- Excellent impact resistance at low temperatures

MARKETS USED

- Automotive Applications
- General Applications
- Industrial Applications
- Sports & Leisure
- Lawn and Garden

APPLICATIONS

- Clips
- Fasteners
- Grips
- Spacers

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.



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