



ALLONYL 1033

Polyamide 6 alloy 30% Glass Fibers reinforced

Allonyl 1033 is a 30% glass reinforced paintable, black injection molding compound designed for office furniture, appliances and automotive applications.

Features

- Stiffness
- Good surface quality
- Excellent dimensional stability

Typical Applications

- Arm support, handles

Typical Resin Properties ^(a)	ASTM Method	Typical values
Density at 23°C, g/cm ³	D792	1.37*
Fiber Glass content, %	D2584	30
Moisture Content, %	D789	0.15
Izod, notched, 23°C, J/m	D256	63*
Tensile Strength @ break (5mm/min), Mpa	D638	122*
Flexural Modulus (1.3mm/min), Mpa	D790	8 000*
Flexural Strength (1.3mm/min), Mpa	D790	188*
HDT, @ 1.8 Mpa, °C	D648	200*

(a) The property values are based on a limited number of tests and, therefore, should not be construed as product specifications.

* Dry as Molded

PROCESSING GUIDELINES

Drying

The Allonyl grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min1.0 CFM/lb, dew point of -18°C or lower. The material should be dried at 70°C (160° F) for 2-4 hours and the humidity content of the material should be maintained below 0.1% during molding.

Molding

Polyamide products have a relatively narrow processing window with barrel temperature settings as following:

- Feed zone: 260-270°C (500-520°F)
- Middle zone: 270-280°C (520-540°F)
- Front zone: 280-290°C (540-550°F)
- Nozzle: 295°C (560°F)
- Melt temperature: 280-290°C (530-550°F)
- Mold temperature: 80-90°C (180-190°F)

Other Molding Parameters

- Injection Pressure: medium
- Injection Speed: Fast to improve aesthetics and reduce stress
- Back Pressure: None
- Screw Speed: Low



ISO 17025



Conseil canadien des normes
Standards Council of Canada

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