



VYLON B 33FHS

Polyamide 6 33% Glass Fibers reinforced

Vylon B33FHS is a 33% glass reinforced, black nylon 6 injection molding compound designed for office furniture applications.

Features

- Stiffness
- Good surface quality
- Excellent dimensional stability

Typical Applications

- Chair bases, arm supports

Typical Resin Properties ^(a)	ASTM Method	Typical values*
Density at 23°C, g/cm ³	D792	1.37
Fiber glass content %	D 2584	33
Moisture content %	D 789	0.15
Izod, notched, 23°C, J/m	D256	104
Tensile Strength @Break (5mm/min), MPa	D638	155
Tenile Elongation @Break, 23°C, %	D638	3
Flexural Strength (1.3mm/min), MPa	D790	245
Flexural Modulus (1.3mm/min), MPa	D790	9000
HDT, @ 1820 Kpa, °C	D648	205

(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 Vylon B grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min 1.0 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 0.2% during molding.

Molding

Vylon B polyamide products have a relatively wide 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: 290°C (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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