

Vydyne® B 33 GF BK EST K1

polyamide 6



Vydyne B 33 GF BK EST K1 is standard flow, heat stabilized, 33% glass-fiber reinforced PA6 resin. Available in black, this product is also lubricated for improved machine feed and flow.

General

Regional Availability	• North America	• Europe	• Asia Pacific
Additive	• Heat Stabilizer	• Lubricant	
Features	• Chemical Resistant • Good Flow	• Gasoline Resistant • High Heat Resistance	• General Purpose • Lubricated
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.39	-	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	0.7	*	%	
Flow : 23°C, 2.00 mm	0.3	*	%	
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	2.1	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	10200	6700	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	183	118	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.9	6.4	%	ISO 527-2

Impact

	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	15	21	kJ/m ²	ISO 180/1A

Thermal

	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	210	-	°C	
0.45 MPa, Unannealed	215	-	°C	
Melting Temperature	220	*	°C	ISO 11357-3

Electrical

	Value	Unit	Test Standard
Comparative Tracking Index (3.00 mm)	450	V	IEC 60112

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Flammability	Value	Test Standard
Flammability		UL 94
1.50 mm	HB	
3.00 mm	HB	

Injection	Value	Unit
Drying Temperature	80 - 90	°C
Drying Time	≥ 3	h
Rear Temperature	230 - 260	°C
Middle Temperature	230 - 260	°C
Front Temperature	230 - 260	°C
Nozzle temperature	230 - 260	°C
Processing (Melt) Temperature	230 - 260	°C
Mold Temperature	80 - 90	°C

