



Hylon® N1000HL

Ravago Manufacturing Americas, LLC - Polyamide 66

Friday, 29 October 2010

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
Uses	• Automotive Applications
RoHS Compliance	• RoHS Compliant
Automotive Specifications	• FORD WSK-M4D648-A Color: Black
Forms	• Pellets
Processing Method	• Injection Molding

ASTM and ISO Properties ¹

Physical	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Specific Gravity	1.14	--		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.014 to 0.019	--	in/in	ASTM D955
Water Absorption (24 hr)	1.3	--	%	ASTM D570
Mechanical	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Tensile Strength (73°F)	12000	9500	psi	ASTM D638
Tensile Elongation (Break, 73°F)	30	200	%	ASTM D638
Flexural Modulus (73°F)	440000	190000	psi	ASTM D790
Flexural Strength (73°F)	16500	5900	psi	ASTM D790
Impact	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Notched Izod Impact (73°F)	1.0	2.5	ft-lb/in	ASTM D256
Hardness	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Rockwell Hardness (M-Scale)	85	60		ASTM D785
Thermal	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed	460	430	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	190	160	°F	ASTM D648
CLTE - Flow	0.000046	--	in/in/°F	ASTM D696
Electrical	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Volume Resistivity	1.0E+15	1.0E+13	ohm-cm	ASTM D257
Dielectric Strength				ASTM D149
--	--	550	V/mil	
-- 2	580	--	V/mil	
Dielectric Constant				ASTM D150
73°F, 100 Hz	3.70	6.00		

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Flammability	Hylon® N1000HL	Hylon® N1000HL	Unit	Test Method
Flame Rating - UL (0.0590 in)	V-2	V-2		UL 94

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature	165	°F	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	520 to 560	°F	
Mold Temperature	120 to 200	°F	
Back Pressure	50.0 to 100	psi	
Screw Speed	40 to 140	rpm	

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² Method A (Short-Time)