



Hylon® N1013STHL

Ravago Manufacturing Americas, LLC - Polyamide 66

Friday, 29 October 2010

General Information

General

Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass Fiber Reinforcement, 13% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Features	• Heat Stabilized	• Lubricated	• Ultra High Toughness
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM and ISO Properties ¹

Physical	Hylon® N1013STHL	Hylon® N1013STHL	Unit	Test Method
Specific Gravity	1.18	--		ASTM D792
Density	1.18	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.0050 to 0.0080	--	in/in	ASTM D955
Molding Shrinkage - Flow	0.60 to 0.90	--	%	ISO 294-4
Water Absorption (24 hr)	0.70	--	%	ASTM D570
Mechanical	Hylon® N1013STHL	Hylon® N1013STHL	Unit	Test Method
Tensile Strength (Yield, 73°F)	13000	8000	psi	ASTM D638
Tensile Stress (Yield, 73°F)	12500	--	psi	ISO 527-2
Tensile Elongation (Break, 73°F)	3.2	8.0	%	ASTM D638
Tensile Strain (Break, 73°F)	3.5	--	%	ISO 527-2
Flexural Modulus (73°F)	525000	350000	psi	ASTM D790
Flexural Modulus (73°F)	522000	--	psi	ISO 178
Flexural Strength (73°F)	20000	7000	psi	ASTM D790
Flexural Strength (73°F)	18900	--	psi	ISO 178
Impact	Hylon® N1013STHL	Hylon® N1013STHL	Unit	Test Method
Notched Izod Impact (73°F)	3.2	4.0	ft-lb/in	ASTM D256
Notched Izod Impact Strength 73°F	7.1	--	ft-lb/in ²	ISO 180
Hardness	Hylon® N1013STHL	Hylon® N1013STHL	Unit	Test Method
Rockwell Hardness (M-Scale)	80	--		ASTM D785
Thermal	Hylon® N1013STHL	Hylon® N1013STHL	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
264 psi, Unannealed	439	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	448	--	°F	
CLTE - Flow	0.000020	--	in/in/°F	ASTM D696

Customer is responsible for determining whether products and the information in this document are appropriate for Customer's use and for ensuring that Customer's workplace and disposal practices are in compliance with applicable laws and other governmental enactments. Seller assumes no obligation or liability for the information in this document. **NO WARRANTIES ARE GIVEN; ALL IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE ARE EXPRESSLY EXCLUDED.**

Hylon® N1013STHL
Ravago Manufacturing Americas, LLC - Polyamide 66

Flammability	Hylon® N1013STHL	Hylon® N1013STHL	Unit	Test Method
Flame Rating - UL				UL 94
0.0590 in	HB	--		
0.0591 in, BK	--	HB		

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature	165	°F	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.18	%	
Processing (Melt) Temp	540 to 570	°F	
Mold Temperature	150 to 210	°F	
Back Pressure	20.0 to 60.0	psi	
Screw Speed	40 to 120	rpm	

Notes

¹ Typical properties: these are not to be construed as specifications.