



Hylon® N1000EHL

Ravago Manufacturing Americas, LLC - Polyamide 66

Sunday, 28 September 2014

General Information

Product Description

This grade is available in black or colors only

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
RoHS Compliance	• RoHS Compliant
Automotive Specifications	• CHRYSLER MS-DB41 CPN3490 Color: Black 155 • CHRYSLER MS-DB41 CPN3490 Color: Natural
Appearance	• Black • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

ASTM and ISO Properties ¹

Physical	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Specific Gravity	1.14	--		ASTM D792
Density	1.14	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.014 to 0.018	--	in/in	ASTM D955
Molding Shrinkage - Flow	1.4 to 1.9	--	%	ISO 294-4
Water Absorption (24 hr)	1.3	--	%	ASTM D570
Mechanical	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Tensile Strength (Yield, 73°F)	12000	9500	psi	ASTM D638
Tensile Stress (Yield, 73°F)	12200	--	psi	ISO 527-2
Tensile Elongation (Break, 73°F)	30	200	%	ASTM D638
Tensile Strain (Break, 73°F)	25	--	%	ISO 527-2
Flexural Modulus (73°F)	430000	190000	psi	ASTM D790
Flexural Modulus (73°F)	413000	--	psi	ISO 178
Flexural Strength (73°F)	16500	5900	psi	ASTM D790
Flexural Stress (73°F)	17400	--	psi	ISO 178
Impact	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Notched Izod Impact (73°F)	1.0	2.5	ft·lb/in	ASTM D256
Notched Izod Impact Strength 73°F	2.5	--	ft·lb/in ²	ISO 180
Hardness	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Rockwell Hardness (M-Scale)	85	60		ASTM D785
Thermal	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed	460	430	°F	ASTM D648

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Thermal	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Heat Deflection Temperature 66 psi, Unannealed	410	--	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	190	160	°F	ASTM D648
Heat Deflection Temperature 264 psi, Unannealed	163	--	°F	ISO 75-2/A
Electrical	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Volume Resistivity	1.0E+16	1.0E+13	ohm·cm	ASTM D257
Dielectric Strength				ASTM D149
--	--	550	V/mil	
-- ²	580	--	V/mil	
Dielectric Constant (100 Hz)	3.70	6.00		ASTM D150
Flammability	Hylon® N1000EHL	Hylon® N1000EHL	Unit	Test Method
Flame Rating				UL 94
0.0280 in, ALL	--	V-2		
0.0280 in	V-2	--		
0.0591 in, ALL	--	V-2		
0.118 in, ALL	--	V-2		
Additional Information				
Hylon® N1000EHL	Dielectric Strength, ASTM D149, Short Time, 73°F: 550 V/mil			

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)