

Promyde® B33 L

Polyamide 6

NUREL, S.A.

Message:

Promyde® B33L is a high viscosity lubricated Polyamide 6.

CHARACTERISTICS

Promyde B33 L is a high viscosity polyamide 6 lubricated for injection and extrusion.

APPLICATIONS

Promyde B33 L allows a fast and efficient mould filling and an easy mould release, that combined with its excellent mechanical and thermal properties, make it suitable for components used in technical parts in mechanical, automotive, electrical and electronic industries.

General Information				
Additive	Lubricant			
Features	Fast molding cycle			
	Good formability			
	Lubrication			
	Good demoulding performance			
	Viscosity, High			
Uses	Electrical/Electronic Applications			
	Application in Automobile Field			
Processing Method	Extrusion			
	Injection molding			
Physical	Dry	Conditioned	Unit	Test Method
Density (23°C)	1.13	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	35.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				
Vertical flow direction	0.90 - 1.1	--	%	
Flow direction	1.0 - 1.2	--	%	
Water Absorption				ISO 62
Saturated, 23°C	9.5	--	%	ISO 62
Equilibrium, 23°C, 50% RH	3.0	--	%	ISO 62
Viscosity Number	203	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	3300	1100	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	85.0	40.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	4.0	25	%	ISO 527-2/50
Nominal Tensile Strain at Break (23°C)	50	> 50	%	ISO 527-2/50

Flexural Modulus ¹ (23°C)	2800	1000	MPa	ISO 178
Flexural Stress ² (23°C)	110	30.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	35	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	197	--	°C	ISO 75-2/B
1.8 MPa, not annealed	65.0	--	°C	ISO 75-2/A
Melting Temperature (DSC) ³	222	--	°C	ISO 3146
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 80°C	7.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral: 23 to 80°C	1.0E-4	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+13	1.0E+10	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+12	ohms·cm	IEC 60093
Dielectric Constant (1 MHz)	3.50	7.00		IEC 60250
Dissipation Factor (1 MHz)	0.023	0.30		IEC 60250
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm)	V-2	--		UL 94
Injection	Dry	Unit		
Drying Temperature	< 80.0		°C	
Drying Time	4.0 - 6.0		hr	
Processing (Melt) Temp	250 - 270		°C	
Mold Temperature	40.0 - 80.0		°C	
Injection Rate	Moderate-Fast			
Injection instructions				
Back Pressure: moderate				
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			
3.	10°C/min			

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