

Vydyne® R633H01

polyamide 66/6 copolymer



Vydyne R633H01 is 33% glass-fiber reinforced PA66/6 copolymer resin for superior surface appearance. Available in black, this injection-molding grade resin is lubricated for machine feed and mold release.

Vydyne R633H01 has tensile strength and modulus properties just below aluminum and zinc and can replace these metals in numerous applications due to an excellent balance of properties. Reduction in production costs, energy consumption, and part weight are key advantages of Vydyne glass-reinforced PA66/6 resins over aluminum and/or zinc die-cast parts.

Vydyne R633H01 is specially formulated to minimize the oxidative and thermal degradation of the PA66/6 copolymer when exposed to elevated temperatures for extended periods of time. Product provides improved retention of physical properties under exposure to longterm heat.

Vydyne R633H01 provides a higher heat distortion temperature, better resistance to creep, higher impact and better dimensional stability compared with unreinforced PA66/6. This product also provides a combination of excellent surface appearance with high tensile and modulus properties. This property balance enables usage of Vydyne R633H01 in applications where aesthetics and performance are important.

Typical Applications/End Uses:

Vydyne R633H01 resin has been used for many under-the-hood automotive applications, motor housings for power tools, and garden appliances. These resins have also been used in miscellaneous brackets, gears and clips that require high rigidity and strength.

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Features	• Copolymer • Good Mold Release	• Good Surface Finish • Heat Stabilized	• High Tensile Strength • Lubricated
Uses	• Electrical/Electronic Applications • Housings	• Lawn and Garden Equipment • Metal Replacement	• Power/Other Tools
Agency Ratings	• ASTM D4066 PA112G35	• ASTM D6779 PA082G35	
Automotive Specifications	• CHRYSLER MS-DB-41 CPN 3275 • CHRYSLER MS-DB-41 CPN 4405	• FORD ESB-M4D133-A • FORD ESL-M4D533-A	• GM GMP.PA66/6.002 • GM GMP.PA66/6.004
UL File Number	• E70062		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Vydyne® R633H01
polyamide 66/6 copolymer



Physical	Dry	Conditioned	Unit	Test Method
Density	1.39	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	0.90	--	%	
Flow : 23°C, 2.00 mm	0.40	--	%	
Water Absorption				ISO 62
24 hr, 23°C	1.3	--	%	
Equilibrium, 23°C, 50% RH	2.3	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10800	8000	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	184	130	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	4.0	6.0	%	ISO 527-2
Flexural Modulus (23°C)	8800	6800	MPa	ISO 178
Flexural Strength (23°C)	255	195	MPa	ISO 178
Poisson's Ratio	0.40	--		ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	11	15	kJ/m ²	
23°C	12	25	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	44	91	kJ/m ²	
23°C	51	92	kJ/m ²	
Notched Izod Impact Strength				ISO 180
-30°C	12	19	kJ/m ²	
23°C	13	22	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	230	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	220	--	°C	ISO 75-2/A
Melting Temperature	233	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	1.5E-5	--	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	1.0E-4	--	cm/cm/°C	

Vydyne® R633H01
polyamide 66/6 copolymer



Electrical	Dry	Conditioned	Unit	Test Method
Arc Resistance (3.00 mm)	5.00	--	sec	ASTM D495
Comparative Tracking Index (3.00 mm)	250 to 399	--	V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.75 mm	PLC 0	--		
1.5 mm	PLC 0	--		
3.0 mm	PLC 0	--		
High Voltage Arc Tracking Rate (HVTR)	PLC 2	--		UL 746
Hot-wire Ignition (HWI)				UL 746
0.75 mm	PLC 4	--		
1.5 mm	PLC 4	--		
3.0 mm	PLC 3	--		
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.75 mm	HB	--		
1.5 mm	HB	--		
3.0 mm	HB	--		
Injection		Dry <td>Unit</td> <td></td>	Unit	
Drying Temperature			80 °C	
Drying Time			4.0 hr	
Suggested Max Regrind			25 %	
Rear Temperature			280 to 310 °C	
Middle Temperature			280 to 310 °C	
Front Temperature			280 to 310 °C	
Nozzle Temperature			280 to 310 °C	
Processing (Melt) Temp			285 to 305 °C	
Mold Temperature			65 to 95 °C	

Notes

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

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



North America

+1 888 927 2363

Europe

+32 10 608 600

Asia

+86 21 2315 0888

Disclaimer of Warranty and Liability

NOTICE: Although the information and recommendations set forth herein (hereinafter "information") are presented in good faith and believed to be correct as of the date hereof, Ascend Performance Materials Operations makes no representations or warranties as to the completeness or accuracy thereof.

Information is supplied upon the condition that the persons receiving same will make their own determination as to its suitability for their purposes prior to use. In no event will Ascend Performance Materials Operations be responsible for damages of any nature whatsoever resulting from the use of or reliance upon information or the products to which information refers. Nothing contained herein is to be construed as a recommendation to use any product, equipment or formulation in conflict with any patent, and Ascend Performance Materials Operations makes no representation or warranty, express or implied, that use thereof will not infringe any patent. No representations or warranties, either express or implied, of merchantability, fitness for a particular purpose or of any other nature are made hereunder with respect to information or the product to which information refers.