

# AVP™ RY633CP

Polyamide 6  
SABIC Innovative Plastics

Message:

AVP™ RY633CP is a Polyamide 6 (Nylon 6) product filled with 33% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: heat stabilizer.

General Information			
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (Ultimate, 3.18 mm)	138	MPa	ASTM D638
Flexural Modulus <sup>2</sup> (3.18 mm, 50.8 mm Span)	6210	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	69	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	210	°C	ASTM D648
Melting Temperature	216	°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	40 to 80	%	
Rear Temperature	227 to 260	°C	
Middle Temperature	243 to 277	°C	
Front Temperature	260 to 293	°C	
Nozzle Temperature	260 to 293	°C	
Processing (Melt) Temp	260 to 293	°C	
Mold Temperature	65.6 to 110	°C	
Back Pressure	0.172 to 1.03	MPa	
Screw Speed	50 to 150	rpm	
NOTE			
1.	5.1 mm/min		

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#### Recommended distributors for this material

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