

# Rhelon G1033H-01

Polyamide 6  
RheTech, Inc.

Message:

Rhelon G1033H-01 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		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.20 to 0.50	%	
Across Flow	0.70 to 1.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	166	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	2.0	%	
Break	2.0	%	
Flexural Modulus	8960	MPa	ASTM D790
Flexural Strength	241	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	212	°C	ASTM D648
Peak Melting Temperature	216	°C	ASTM D789
CLTE - Flow	5.3E-6	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Suggested Max Moisture	0.20	%	
Suggested Max Regrind	25	%	
Rear Temperature	218 to 235	°C	
Middle Temperature	241 to 263	°C	
Front Temperature	246 to 268	°C	
Nozzle Temperature	246 to 268	°C	
Processing (Melt) Temp	249 to 266	°C	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

