

Polyamide 66

lubricant modified, natural color

Physical properties		Test method	Units	Typical value
Specific gravity		ISO 1183	g/cm ³	1,15
Water absorption	23°C / 24h	ISO 62	%	2,5
Viscosity number		ISO 307	mL/g	145
Flammability behaviour	1,6 mm	UL 94		HB

Mechanical properties at 23°C / 50% rh

Tensile strength	dry, @50 mm/min	ISO 527	MPa	90
Elongation @Fmax.	dry, @50 mm/min	ISO 527	%	8
Tensile modulus	dry, @1 mm/min	ISO 527	GPa	3,5
Impact strength	dry	ISO 179 1eU	kJ/m ²	NB
Impact strength, notched	dry	ISO 179 1eA	kJ/m ²	3,3

Thermal properties

Vicat softening temp.	VST A	DIN ISO 306	°C	240
Heat distortion temp.	HDT A	ISO 75	°C	75
Heat distortion temp.	HDT B	ISO 75	°C	220

Main features

Emergency (dry) running capability. Isotropic shrinkage characteristics.

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Recommended processing parameters**Delivery form & storage**

Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.

Predrying

It is advisable to predry the granules with a suitable dryer immediately before processing. The granule may absorb moisture from the environment.

Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	75	6 - 16
Vacuum Dryer	105	4 - 6

Recommended processing parameters

In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!

Mold	Nozzle	Zone 3	Zone 2	Zone 1
90 - 120 °C	280 - 300 °C	290 - 310 °C	290 - 310 °C	290 - 310 °C

Additional information

During processing the moisture level should not exceed 0.05%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. Excessively high predrying temperatures may cause discoloration. The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application. Please contact us for further information.

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