

Isocor™ HW69SI

Polyamide 610

Shakespeare Monofilaments and Specialty Polymers

Message:

Isocor™ HW69SI is a medium viscosity PA-610. This resin is specifically suited for applications requiring low moisture absorption and greater dimensional stability. Isocor™ HW69SI is also used in applications requiring good electrical insulation properties. This resin can be processed using conventional techniques.

Typical applications for HW69SI include:

- cable jacketing
- film extrusions
- monofilaments / bristles
- automotive tubing
- electrical connectors

General Information	
Features	Good dimensional stability Low hygroscopicity Insulation Medium viscosity
Uses	Films monofilament Cable sheath Pipe fittings Insulating material Connector Application in Automobile Field
Forms	Particle
Processing Method	Film extrusion Injection molding

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.07	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.1	--	%	ASTM D955
Water Absorption (24 hr)	--	1.4	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength	60.0	51.7	MPa	ASTM D638
Tensile Elongation (Break)	100	300	%	ASTM D638
Flexural Modulus	2000	1300	MPa	ASTM D790
Taber Abrasion Resistance (1000 Cycles)	6.00	--	mg	ASTM D1044

Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	48	200	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, not annealed	175	160	°C	ASTM D648
1.8 MPa, not annealed	66.1	60.0	°C	ASTM D648
Melting Temperature	215	--	°C	DSC
Injection	Dry	Unit		
Dew Point	< -17.8		°C	
Suggested Max Moisture	0.20		%	
Hopper Temperature	79.4		°C	
Rear Temperature	221 - 243		°C	
Middle Temperature	227 - 260		°C	
Front Temperature	238 - 271		°C	
Nozzle Temperature	238 - 271		°C	
Processing (Melt) Temp	238 - 271		°C	
Mold Temperature	10.0 - 93.3		°C	
Injection Pressure	3.45 - 13.8		MPa	
Injection Rate	Fast			
Back Pressure	0.345		MPa	
Extrusion	Dry	Unit		
Suggested Max Moisture	0.10		%	
Hopper Temperature	79.4		°C	
Cylinder Zone 1 Temp.	254		°C	
Cylinder Zone 2 Temp.	266		°C	
Cylinder Zone 3 Temp.	271		°C	
Cylinder Zone 4 Temp.	271		°C	
Die Temperature	271		°C	
Extrusion instructions				

Flange: 500°F (260°C) Air Dew Point (max): 0°F (-18°C) Neck: 500°F (260°C) Head: 480°F (250°C) Pump: 480°F (250°C) L/D Ratio: 24 to 30:1 Compression Ratio: 3.5:1 Polymer @ Die: 430°F (220°C) Screw Pressure: 2000 psi

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