

Wellamid® 22LHI3 XE-N

Polyamide 66
Wellman Engineering Resins

Message:

Wellamid® 22LHI3 XE-N is a Polyamide 66 (Nylon 66) material. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Primary attribute of Wellamid® 22LHI3 XE-N: Impact Modified.

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.12	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	1.9 to 2.3	%	
Flow	1.7 to 2.1	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	70.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	60	%	ISO 527-2
Flexural Modulus (23°C)	2400	MPa	ISO 178
Flexural Stress (23°C)	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	12	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	277 to 293	°C	
Middle Temperature	271 to 288	°C	
Front Temperature	266 to 282	°C	
Nozzle Temperature	266 to 293	°C	
Processing (Melt) Temp	271 to 304	°C	
Mold Temperature	71.1 to 93.3	°C	
Injection Pressure	34.5 to 138	MPa	
Back Pressure	0.345	MPa	

Screw Speed

30 to 120

rpm

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Recommended distributors for this material

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