

# Ecomass® 2150TU96

Polyamide 66

Ecomass Technologies

## Message:

Ecomass®2150TU96 is a polyamide 66 (nylon 66) material containing a tungsten filler. This product is available in North America and is processed by injection molding.

Ecomass®The main features of 2150TU96 are:

Good toughness

non-toxic

| General Information                  |                   |                    |                 |
|--------------------------------------|-------------------|--------------------|-----------------|
| Filler / Reinforcement               | Tungsten packing  |                    |                 |
| Features                             | Good toughness    |                    |                 |
|                                      | Non-toxic         |                    |                 |
| Forms                                | Particle          |                    |                 |
| Processing Method                    | Injection molding |                    |                 |
| Physical                             | Nominal Value     | Unit               | Test Method     |
| Density                              | 11.0              | g/cm <sup>3</sup>  | Internal method |
| Molding Shrinkage                    | 0.90 - 1.0        | %                  | Internal method |
| Mechanical                           | Nominal Value     | Unit               | Test Method     |
| Tensile Modulus                      | 3000              | MPa                | ISO 527-2       |
| Tensile Stress (Yield)               | 35.0              | MPa                | ISO 527-2       |
| Tensile Strain (Break)               | 2.0               | %                  | ISO 527-2       |
| Flexural Modulus                     | 4100              | MPa                | ISO 178         |
| Impact                               | Nominal Value     | Unit               | Test Method     |
| Notched Izod Impact                  | 5.0               | kJ/m <sup>2</sup>  | ISO 180/A       |
| Injection                            | Nominal Value     | Unit               |                 |
| Drying Temperature - Desiccant Dryer | 79.4              | °C                 |                 |
| Drying Time - Desiccant Dryer        | 2.0               | hr                 |                 |
| Drying Time, Maximum                 | 4.0               | hr                 |                 |
| Processing (Melt) Temp               | 199 - 221         | °C                 |                 |
| Mold Temperature                     | 54.4 - 65.6       | °C                 |                 |
| Injection Rate                       | Moderate-Fast     |                    |                 |
| Back Pressure                        | 0.103 - 0.172     | MPa                |                 |
| Screw Speed                          | 100 - 250         | rpm                |                 |
| Clamp Tonnage                        | 3.4 - 5.5         | kN/cm <sup>2</sup> |                 |
| Cushion                              | 6.35 - 12.7       | mm                 |                 |
| Screw L/D Ratio                      | 20.0:1.0          |                    |                 |
| Screw Compression Ratio              | 2.5:1.0           |                    |                 |
| Injection instructions               |                   |                    |                 |

Pack (Hold) Pressure: 65 to 75% of Injection Pressure Fill Time: 1.0 to 2.0 in/sec Pack (Hold) Time: 10 to 15 sec Cooling Time: As required Feed Throat:  
Cooled Nozzle Type: Reverse Taper Check Type: Free Flow Dryer Dew Point: -20 to -40 °F Minimum Air Flow: 0.8 to 1.0 CFM Injection Pressure: As Required

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