

# Wellamid® MRB40K004-WT1

Polyamide 66

Wellman Engineering Resins

## Message:

Wellamid® MRB40K004-WT1 is a Polyamide 66 (Nylon 66) material filled with 40% mineral. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding.

Typical application of Wellamid® MRB40K004-WT1: Automotive

| General Information                               |                              |                   |             |
|---------------------------------------------------|------------------------------|-------------------|-------------|
| Filler / Reinforcement                            | Mineral,40% Filler by Weight |                   |             |
| Forms                                             | Pellets                      |                   |             |
| Processing Method                                 | Injection Molding            |                   |             |
| Physical                                          | Nominal Value                | Unit              | Test Method |
| Density                                           | 1.52                         | g/cm <sup>3</sup> | ISO 1183    |
| Molding Shrinkage                                 |                              |                   | ISO 294-4   |
| Across Flow : 23°C                                | 1.3 to 1.7                   | %                 |             |
| Flow : 23°C                                       | 1.1 to 1.5                   | %                 |             |
| Mechanical                                        | Nominal Value                | Unit              | Test Method |
| Tensile Stress (Yield, 23°C)                      | 90.0                         | MPa               | ISO 527-2   |
| Tensile Strain (Yield, 23°C)                      | 4.0                          | %                 | ISO 527-2   |
| Flexural Modulus (23°C)                           | 6000                         | MPa               | ISO 178     |
| Flexural Stress (23°C)                            | 140                          | MPa               | ISO 178     |
| Impact                                            | Nominal Value                | Unit              | Test Method |
| Notched Izod Impact Strength (23°C)               | 4.0                          | kJ/m <sup>2</sup> | ISO 180     |
| Thermal                                           | Nominal Value                | Unit              | Test Method |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 135                          | °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 310                   | °C                |             |
| Middle Temperature                                | 271 to 304                   | °C                |             |
| Front Temperature                                 | 266 to 299                   | °C                |             |
| Nozzle Temperature                                | 254 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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