

Witcom PA66 2006/274

Polyamide 66

Witcom Engineering Plastics B.V.

Message:

Witcom PA66 2006/274 is a polyamide 66 (nylon 66) product that contains fillers. It can be processed by injection molding and is available in Europe.

Features include:

flame retardant/rated flame

Conductivity

Good processability

Halogen-free

General Information			
Filler / Reinforcement	Filler		
Features	Conductivity		
	Good formability		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.20 - 0.40	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	5.5	%	ISO 62
Equilibrium, 23°C, 50% RH	1.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	< 165	MPa	ISO 527-2
Tensile Strain (Break)	2.0 - 4.0	%	ISO 527-2
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress	240	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	8.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	55	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	225	°C	ISO 75-2/A
CLTE - Flow	2.9E-5	cm/cm/°C	ISO 11359-2
RTI Imp (3.00 mm)	100	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+3 - 1.0E+5	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		ISO 1210
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	3.0 - 5.0	hr
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	260 - 280	°C
Mold Temperature	50.0 - 90.0	°C
Injection Rate	Fast	
Back Pressure	0.00 - 1.00	MPa
Injection instructions		

Screw speed: 0.1 - 0.2 m/sInjection pressure: Keep to a minimumHold pressure: Keep to a minimum

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