

VENYL UC406

Polyamide 66

AD majoris

Message:

VENYL UC406 is a 45 % mineral / carbon fibre reinforced polyamide 66 lubricated intended for Injection moulding.

APPLICATIONS

VENYL UC406 has been developed especially for demanding applications for good resistant final parts and rigidity combined with good stiffness and heat stabilization.

Products requiring excellent combination between thermal and mechanical properties.

VENYL UC406 is available only in black (VENYL UC406).

General Information			
Filler / Reinforcement	Carbon\Mineral,45% Filler by Weight		
Additive	Lubricant		
Features	Good Stiffness		
	Good Thermal Stability		
	High Rigidity		
	Lubricated		
	Recyclable Material		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Molding Shrinkage	0.70 to 0.90	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.3	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10200	MPa	ISO 527-2
Tensile Stress (Break)	113	MPa	ISO 527-2
Flexural Modulus	8000	MPa	ISO 178
Flexural Stress	165	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	4.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	31	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	240	°C	ISO 75-2/A
Melting Temperature (DSC)	256	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4	ohms	DIN 53482

Volume Resistivity	1.0E+5	ohms·cm	DIN 53482
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	4.0	hr	
Rear Temperature	295 to 310	°C	
Middle Temperature	290 to 300	°C	
Front Temperature	285 to 295	°C	
Nozzle Temperature	275 to 310	°C	
Mold Temperature	85.0 to 100	°C	
Injection Pressure	85.0 to 110	MPa	
Injection Rate	Fast		
Holding Pressure	50.0 to 70.0	MPa	
Screw L/D Ratio	15.0:1.0 to 20.0:1.0		

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