

Witcom PA66 2010/100 Blue

Polyamide 66

Witcom Engineering Plastics B.V.

Message:

Soft magnetic, metal and X-ray detectable

General Information			
Features	Metal Detectable		
Appearance	Blue		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.71	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.90 - 1.3	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	3.4	%	ISO 62
Equilibrium, 23°C, 50% RH	1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	< 50.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0 - 10	%	ISO 527-2
Flexural Modulus	3500	MPa	ISO 178
Flexural Stress	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	40	kJ/m ²	ISO 180/1U
Flammability	Nominal Value		Test Method
Flame Rating (3.00 mm)	HB		ISO 1210
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0 - 5.0	hr	
Suggested Max Moisture	0.10	%	
Processing (Melt) Temp	275 - 295	°C	
Mold Temperature	60.0 - 95.0	°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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