

Wellamid® FR22F-N

Polyamide 66
Wellman Engineering Resins

Message:

Wellamid® FR22F-N is a Polyamide 66 (Nylon 66) material. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Important attributes of Wellamid® FR22F-N are:
Flame Rated
Flame Retardant
Typical application of Wellamid® FR22F-N: Automotive

General Information			
UL YellowCard	E44600-235489		
Additive	Flame Retardant		
Features	Flame Retardant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.32	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	1.6 to 2.0	%	
Flow : 23°C	1.3 to 1.7	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	65.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	6.0	%	ISO 527-2
Flexural Modulus (23°C)	3900	MPa	ISO 178
Flexural Stress (23°C)	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	4.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	90.0	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	271 to 282	°C	
Middle Temperature	266 to 277	°C	
Front Temperature	260 to 271	°C	
Nozzle Temperature	271 to 282	°C	

Processing (Melt) Temp	266 to 277	°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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

