

# VENYL UM108 - 8689

Polyamide 66

AD majoris

## Message:

VENYL UM108 - 8689 is a 15 % mineral filled polyamide 66 medium viscosity intended for Injection moulding.

### APPLICATIONS

VENYL UM108 - 8689 has been developed especially for very demanding applications in automotive industry and electrical parts.

General Information			
Filler / Reinforcement	Mineral,15% Filler by Weight		
Features	Medium Viscosity		
	Recyclable Material		
Uses	Automotive Applications		
	Electrical Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage	0.90 to 1.3	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.9	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	85.0	MPa	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Flexural Modulus	3850	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	6.5	kJ/m <sup>2</sup>	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	205	°C	ISO 75-2/B
1.8 MPa, Unannealed	185	°C	ISO 75-2/A
Melting Temperature (DSC)	256	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	DIN 53482
Volume Resistivity	1.0E+14	ohms · cm	DIN 53482
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	

Drying Temperature	80.0 to 100	°C
Drying Time	4.0	hr
Rear Temperature	285 to 300	°C
Middle Temperature	280 to 285	°C
Front Temperature	275 to 290	°C
Nozzle Temperature	265 to 280	°C
Mold Temperature	90.0 to 120	°C
Injection Pressure	85.0 to 100	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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