

Witcom PA66 6LC-EM-HS

Polyamide 66

Witcom Engineering Plastics B.V.

Message:

Witcom PA66 6LC-EM-HS is a polyamide 66 (nylon 66) product that contains 30% long carbon fiber as filler. It can be processed by injection molding and is available in Europe.

- Features include:
- flame retardant/rated flame
 - Conductivity
 - Good processability
 - heat stabilizer

General Information			
Filler / Reinforcement	Long carbon fiber, 30% filler by weight		
Additive	heat stabilizer		
Features	Conductivity		
	Good formability		
	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.20 - 0.30	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	5.8	%	ISO 62
Equilibrium, 23°C, 50% RH	1.7	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	24000	MPa	ISO 527-2
Tensile Stress (Yield)	< 305	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	22500	MPa	ISO 178
Flexural Stress	420	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	18	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	55	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		ISO 1210

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	280 - 300	°C
Mold Temperature	80.0 - 170	°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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