

AIE PA66 60G6ST

Polyamide 66

Asia International Enterprise (Hong Kong) Limited

Message:

AIE PA66 60G6ST is a polyamide 66 (nylon 66) material, which contains a filler of 30% glass fabric reinforcement. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is injection molding.

The main features of AIE PA66 60G6ST are:

- flame retardant/rated flame
- Hard
- Good dimensional stability

General Information			
Filler / Reinforcement	Glass fabric reinforcement, 30% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage	0.40 - 0.80	%	Internal method
Water Absorption (23°C, 24 hr)	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	210	MPa	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2
Flexural Modulus	5500	MPa	ISO 178
Flexural Stress	310	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	25	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	255	°C	ISO 75-2/B
1.8 MPa, not annealed	235	°C	ISO 75-2/A
Flammability	Nominal Value	Test Method	
Flame Rating	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	250 - 280	°C	
Middle Temperature	240 - 270	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	250 - 280	°C	

Mold Temperature	50.0 - 110	°C
Injection Pressure	30.0 - 80.0	MPa
Holding Pressure	40.0 - 50.0	MPa
Back Pressure	5.00 - 10.0	MPa

Injection instructions

Cylinder Temperature 4: 240 to 260°C

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