

# ESTOPLAST XU 6310GY01

Polyamide 66  
Ester Industries Ltd.

Message:

Polyamide 66 - Mineral Filled, 10%  
Automotive: Wheel cover, Exterior trim, interior trim, Electrical components and connectors  
Electrical & Electronic: Low voltage switch gear/power distribution, Lighting, Power connectors ,

| General Information               |                                      |                   |             |
|-----------------------------------|--------------------------------------|-------------------|-------------|
| Filler / Reinforcement            | Mineral filler, 10% filler by weight |                   |             |
| Additive                          | demoulding                           |                   |             |
| Features                          | Good dimensional stability           |                   |             |
|                                   | Good demoulding performance          |                   |             |
| Uses                              | Lighting Applications                |                   |             |
|                                   | Electrical/Electronic Applications   |                   |             |
|                                   | Connector                            |                   |             |
|                                   | Application in Automobile Field      |                   |             |
|                                   | Car interior equipment               |                   |             |
|                                   | Car exterior decoration              |                   |             |
| RoHS Compliance                   | RoHS compliance                      |                   |             |
| Appearance                        | Grey                                 |                   |             |
| Forms                             | Particle                             |                   |             |
| Processing Method                 | Injection molding                    |                   |             |
| Physical                          | Nominal Value                        | Unit              | Test Method |
| Specific Gravity                  | 1.20                                 | g/cm <sup>3</sup> | ASTM D792   |
| Water Absorption                  |                                      |                   | ISO 62      |
| Saturated, 23°C                   | 4.5                                  | %                 | ISO 62      |
| Equilibrium, 23°C, 50% RH         | 1.6                                  | %                 | ISO 62      |
| Mechanical                        | Nominal Value                        | Unit              | Test Method |
| Tensile Strength (Break)          | 72.0                                 | MPa               | ASTM D638   |
| Tensile Elongation (Break)        | 15                                   | %                 | ASTM D638   |
| Flexural Strength                 | 110                                  | MPa               | ASTM D790   |
| Impact                            | Nominal Value                        | Unit              | Test Method |
| Notched Izod Impact (23°C)        | 45                                   | J/m               | ASTM D256A  |
| Thermal                           | Nominal Value                        | Unit              | Test Method |
| Deflection Temperature Under Load |                                      |                   | ASTM D648   |
| 0.45 MPa, not annealed            | 230                                  | °C                | ASTM D648   |
| 1.8 MPa, not annealed             | 70.0                                 | °C                | ASTM D648   |
| Injection                         | Nominal Value                        | Unit              |             |

|                        |           |    |
|------------------------|-----------|----|
| Drying Temperature     | 85 - 90   | °C |
| Drying Time            | 3.0 - 4.0 | hr |
| Rear Temperature       | 270 - 280 | °C |
| Middle Temperature     | 280 - 290 | °C |
| Nozzle Temperature     | 275 - 285 | °C |
| Processing (Melt) Temp | 275 - 285 | °C |
| Mold Temperature       | 55 - 80   | °C |

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