

Heramid® A GRI 7645 ECP1904

Polyamide 66

Radici Plastics

Message:

PA66 15% mineral filled injection moulding grade. Heat stabilized. Toughened. Grey colour.

Post-industrial grade produced with selected polymers coming from polymerization, fibres and compounding plants.

ISO 1043 : PA66-I MX15

General Information			
Filler / Reinforcement	Mineral,15% Filler by Weight		
Additive	Heat Stabilizer		
Recycled Content	Yes		
Features	Good Toughness		
	Heat Stabilized		
RoHS Compliance	RoHS Compliant		
Appearance	Grey		
Processing Method	Injection Molding		
Resin ID (ISO 1043)	PA66-I MX15		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	70.0	MPa	ISO 527-2/1A/5
Nominal Tensile Strain at Break	10	%	ISO 527-2/1A/50
Flexural Modulus ¹	3200	MPa	ISO 178
Flexural Stress ²	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	80	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	80.0	°C	ISO 75-2/Af
Vicat Softening Temperature	90.0	°C	ISO 306/B50
Melting Temperature ³	265	°C	ISO 11357
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	80.0	°C	
Drying Time - Desiccant Dryer	2.0 to 4.0	hr	
Dew Point - Desiccant Dryer	< -20.0	°C	
Suggested Max Moisture	0.15	%	
Processing (Melt) Temp	280 to 300	°C	

Mold Temperature	80.0 to 100	°C
Injection Rate	Moderate-Fast	
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	10°C/min	

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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



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