

Witcom PA66 4L1

Polyamide 66

Witcom Engineering Plastics B.V.

Message:

Witcom PA66 4L1 is a polyamide 66 (nylon 66) product. It can be processed by injection molding and is available in Europe.

Features include:

flame retardant/rated flame

Lubrication

General Information			
Additive	PTFE lubricant (20%)		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	1.3 - 1.8	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	6.8	%	ISO 62
Equilibrium, 23°C, 50% RH	2.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	70.0	MPa	ISO 527-2
Tensile Strain (Break)	> 8.0	%	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	75	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	80.0	°C	ISO 75-2/A
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
RTI Imp (3.00 mm)	90.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		ISO 1210
Glow Wire Flammability Index (1.60 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	Test Method
Drying Temperature	80.0	°C	
Drying Time	3.0 - 5.0	hr	
Suggested Max Moisture	0.10	%	

Processing (Melt) Temp	275 - 295	°C
Mold Temperature	60.0 - 95.0	°C
Injection Rate	Fast	
Back Pressure	0.00 - 1.00	MPa

Injection instructions

Screw speed: 0.1 to 0.2 m/sInjection pressure: Keep to a minimumHold pressure: Keep to a minimum

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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

