Ecomass® 1850ZN66T1

Polyamide 6

Ecomass Technologies

Message:

Ecomass®1850ZN66T1 is a polyamide 6 (nylon 6) material that contains a steel filler. This product is available in North America and is processed by injection molding. Ecomass®The main characteristics of 1850ZN66T1 are: impact modification.

General Information			
Filler / Reinforcement	Steel filler		
Additive	Impact modifier		
Features	Impact modification		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	2.49	g/cm³	Internal method
Molding Shrinkage	0.80 - 1.0	%	Internal method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Yield)	31.0	MPa	ISO 527-2
Tensile Strain (Break)	10	%	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	7.5	kJ/m²	ISO 180/A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	150	°C	ISO 75-2/B
1.8 MPa, not annealed	50.0	°C	ISO 75-2/A
Injection	**Nominal Value**	**Unit**	
Drying Temperature - Desiccant Dryer	73.9 - 79.4	°C	
Drying Time - Desiccant Dryer	4.0 - 6.0	hr	
Processing (Melt) Temp	232 - 260	°C	
Mold Temperature	57.2 - 79.4	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 - 0.172	MPa	
Screw Speed	100 - 250	rpm	
Clamp Tonnage	3.4 - 5.5	kN/cm²	
Cushion	6.35 - 12.7	mm	
Screw L/D Ratio	20.0:1.0		
Screw Compression Ratio	2.5:1.0		
Injection instructions			

Pack (Hold) Pressure: 65 to 75% of Injection PressureFill Time: 1.0 to 2.0 in/secPack (Hold) Time: 10 to 15 secCooling Time: As requiredFeed Throat: CooledNozzle Type: Reverse TaperCheck Type: Free FlowMaximum Drying Temp: 200 °FDryer Dew Point: -20 to -40 °FMinimum Air Flow: 0.8 to 1.0 CFMInjection Pressure: As Required

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