

Generic Nylon 66 - Glass Fiber, Long

Polyamide 66

Generic

Message:

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General Information			
Filler / Reinforcement	Long glass fiber		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.35 - 1.72	g/cm ³	ASTM D792
23°C	1.41 - 1.71	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 23°C	0.14 - 0.31	%	ASTM D955
Transverse flow: 23°C	0.19 - 0.81	%	ASTM D955
23°C	0.18 - 0.81	%	ISO 294-4
Water Absorption			
23°C, 24 hr	9.8E-3 - 0.97	%	ASTM D570
23°C, 24 hr	0.80 - 0.90	%	ISO 62
Saturated, 23°C	3.4	%	ISO 62
Equilibrium, 23°C, 50% RH	1.0 - 1.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	10200 - 23200	MPa	ASTM D638
23°C	11700 - 23300	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	150 - 252	MPa	ASTM D638
Yield, 23°C	150 - 278	MPa	ISO 527-2
Fracture, 23°C	172 - 270	MPa	ASTM D638
Fracture, 23°C	203 - 276	MPa	ISO 527-2
23°C	181 - 252	MPa	ASTM D638
Tensile Elongation			
Yield, 23°C	1.9 - 2.5	%	ASTM D638
Yield, 23°C	1.7 - 2.1	%	ISO 527-2
Fracture, 23°C	1.5 - 2.5	%	ASTM D638
Fracture, 23°C	1.6 - 2.1	%	ISO 527-2
Flexural Modulus			
23°C	7890 - 21400	MPa	ASTM D790
23°C	10000 - 19000	MPa	ISO 178

Flexural Strength			
23°C	242 - 430	MPa	ASTM D790
23°C	243 - 437	MPa	ISO 178
Coefficient of Friction	0.39 - 0.40		ASTM D1894
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	14 - 45	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	59 - 110	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	84 - 510	J/m	ASTM D256
23°C	19 - 55	kJ/m ²	ISO 180
Unnotched Izod Impact			
23°C	530 - 1600	J/m	ASTM D256
23°C	51 - 100	kJ/m ²	ISO 180
Instrumented Dart Impact			
23°C	8.60 - 18.0	J	ASTM D3763
23°C	5.60 - 20.2	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	226 - 260	°C	ASTM D648
0.45 MPa, not annealed	252 - 265	°C	ISO 75-2/B
1.8 MPa, not annealed	241 - 260	°C	ASTM D648
1.8 MPa, not annealed	250 - 263	°C	ISO 75-2/A
8.0 MPa, not annealed	234 - 241	°C	ISO 75-2/C
Melting Temperature	260 - 261	°C	ISO 11357-3
Linear thermal expansion coefficient			
Flow	1.8E-5 - 1.9E-5	cm/cm/°C	ASTM E831
Flow	1.7E-5 - 2.5E-5	cm/cm/°C	ISO 11359-2
Lateral	2.6E-5 - 6.7E-5	cm/cm/°C	ASTM E831
Lateral	5.3E-5 - 6.8E-5	cm/cm/°C	ISO 11359-2
RTI Imp	109 - 110	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+9 - 2.5E+12	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	75.0 - 82.9	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.15 - 0.20	%	
Rear Temperature	287 - 288	°C	
Middle Temperature	293 - 294	°C	
Front Temperature	293 - 294	°C	
Nozzle Temperature	271 - 315	°C	
Processing (Melt) Temp	295 - 296	°C	
Mold Temperature	88.9 - 105	°C	

Injection Pressure	6.89 - 135	MPa
Holding Pressure	64.8 - 70.0	MPa
Back Pressure	0.258 - 0.289	MPa
Screw Speed	44 - 45	rpm

Injection instructions

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