

# Wellamid® XT1668-BK1

Polyamide 66  
Wellman Engineering Resins

Message:

Wellamid® XT1668-BK1 is a Polyamide 66 (Nylon 66) material. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Important attributes of Wellamid® XT1668-BK1 are:  
Impact Modified  
Impact Resistant

| General Information                               |                        |                   |             |
|---------------------------------------------------|------------------------|-------------------|-------------|
| Additive                                          | Impact Modifier        |                   |             |
| Features                                          | High Impact Resistance |                   |             |
|                                                   | Impact Modified        |                   |             |
| Forms                                             | Pellets                |                   |             |
| Processing Method                                 | Injection Molding      |                   |             |
| Physical                                          | Nominal Value          | Unit              | Test Method |
| Density                                           | 1.10                   | g/cm <sup>3</sup> | ISO 1183    |
| Molding Shrinkage                                 |                        |                   | ISO 294-4   |
| Across Flow : 23°C                                | 1.8 to 2.2             | %                 |             |
| Flow : 23°C                                       | 2.0 to 2.4             | %                 |             |
| Mechanical                                        | Nominal Value          | Unit              | Test Method |
| Tensile Stress (Yield, 23°C)                      | 50.0                   | MPa               | ISO 527-2   |
| Tensile Strain (Yield, 23°C)                      | 60                     | %                 | ISO 527-2   |
| Flexural Modulus (23°C)                           | 1900                   | MPa               | ISO 178     |
| Flexural Stress (23°C)                            | 60.0                   | MPa               | ISO 178     |
| Poisson's Ratio                                   | 0.37                   |                   |             |
| Impact                                            | Nominal Value          | Unit              | Test Method |
| Notched Izod Impact Strength (23°C)               | 60                     | kJ/m <sup>2</sup> | ISO 180     |
| Thermal                                           | Nominal Value          | Unit              | Test Method |
| Heat Deflection Temperature (1.8 MPa, Unannealed) | 60.0                   | °C                | ISO 75-2/A  |
| Melting Temperature (DSC)                         | 260                    | °C                | ISO 3146    |
| Injection                                         | Nominal Value          | Unit              |             |
| Drying Temperature                                | 79.4                   | °C                |             |
| Drying Time                                       | 2.0 to 4.0             | hr                |             |
| Suggested Max Moisture                            | 0.20                   | %                 |             |
| Rear Temperature                                  | 277 to 293             | °C                |             |
| Middle Temperature                                | 271 to 288             | °C                |             |
| Front Temperature                                 | 266 to 282             | °C                |             |
| Nozzle Temperature                                | 266 to 293             | °C                |             |

|                        |              |     |
|------------------------|--------------|-----|
| Processing (Melt) Temp | 271 to 304   | °C  |
| Mold Temperature       | 65.6 to 93.3 | °C  |
| Injection Pressure     | 34.5 to 138  | MPa |
| Back Pressure          | 0.345        | MPa |
| Screw Speed            | 30 to 120    | rpm |

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