

Wellamid® 22LH-WBK

Polyamide 66
Wellman Engineering Resins

Message:

Wellamid® 22LH-WBK is a Polyamide 66 (Nylon 66) material. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding.

General Information			
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	1.8 to 2.2	%	
Flow : 23°C	1.6 to 2.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	70.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	25	%	ISO 527-2
Flexural Modulus (23°C)	2700	MPa	ISO 178
Flexural Stress (23°C)	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	5.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°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	71.1 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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