

PPR PA6603

Polyamide 66

Premier Plastic Resins, Inc.

Message:

Reprocessed Nylon 6/6 33% Glass Fiber Reinforced Black

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	124	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus - Tangent	8280	MPa	ASTM D790
Flexural Strength	200	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	249	°C	ASTM D648
1.8 MPa, not annealed	74.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	74.0 - 85.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	282 - 304	°C	
Middle Temperature	277 - 299	°C	
Front Temperature	271 - 299	°C	
Nozzle Temperature	266 - 293	°C	
Processing (Melt) Temp	282 - 299	°C	
Mold Temperature	38.0 - 93.0	°C	
Injection Pressure	55.0 - 138	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	41.0 - 103	MPa	
Back Pressure	0.00 - 1.00	MPa	
Cushion	6.35 - 12.7	mm	

Injection instructions

Screw Speed: SlowDecompression: 3.81 to 7.6 mm

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Recommended distributors for this material

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