

Wellamid® MR409 22H-NBK1

Polyamide 66
Wellman Engineering Resins

Message:

Wellamid® MR409 22H-NBK1 is a Polyamide 66 (Nylon 66) material filled with 40% mineral. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Primary attribute of Wellamid® MR409 22H-NBK1: Flame Rated.
Typical application of Wellamid® MR409 22H-NBK1: Automotive

General Information			
UL YellowCard	E44600-235480		
Filler / Reinforcement	Mineral,40% Filler by Weight		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	1.1 to 1.5	%	
Flow : 23°C	1.2 to 1.6	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	80.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	6.0	%	ISO 527-2
Flexural Modulus (23°C)	5700	MPa	ISO 178
Flexural Stress (23°C)	125	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)	110	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Flammability	Nominal Value		Test Method
Flame Rating (0.750 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	282 to 304	°C	
Middle Temperature	277 to 299	°C	
Front Temperature	271 to 293	°C	
Nozzle Temperature	282 to 293	°C	
Processing (Melt) Temp	271 to 310	°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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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

