

ECONAMID® 66FL

Polyamide 66

DOMO Engineering Plastics SPA

Message:

Polyamide 66, for injection moulding.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹ (23°C, 72 hr)	1.4 to 1.6	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2900	MPa	ISO 527-2/1
Tensile Stress (Yield)	70.0	MPa	ISO 527-2/50
Tensile Strain (Break)	45	%	ISO 527-2/50
Flexural Modulus ²	2400	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	195	°C	ISO 75-2/B
1.8 MPa, Unannealed	80.0	°C	ISO 75-2/A
Vicat Softening Temperature	235	°C	ISO 306/B50
Melting Temperature	258 to 262	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Processing (Melt) Temp	265 to 285	°C	
Mold Temperature	70.0 to 120	°C	
NOTE			
1.	50% RH		
2.	2.0 mm/min		

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Recommended distributors for this material

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