

ECONAMID® FL 66

Polyamide 66, for injection moulding

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA66
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,14
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	2900
Tensile strain at break	50 mm/min	ISO 527	[%]	45
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	70
Flexural modulus	2 mm/min	ISO 178	[MPa]	2400
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	5
Hardness Rockwell		ISO 2039/2	[ScaleR]	118
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	262
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	195
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	80
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	235
ELECTRICAL				
Volume resistivity		IEC 62631-3-1	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 62631-3-2	[Ω]	10 ¹³
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products

PROCESSING CONDITIONS:

Drying temperature/time	: 75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	: 265-285 °C
Recommended mould temperature	: 70-120 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. ECONAMID grades are not recommended for injection moulding hot runner systems with a diameter below 1mm

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