

LATIMASS 66-04 D009

Specific density compound based on Polyamide 66 (PA66).
Special filler.

PHYSICAL PROPERTIES	STANDARD	VALUE	MEASURE	UNITS
Density	ISO 1183	0.90	g/cm ³	
Linear shrinkage at moulding				
Longitudinal (2.0mm/60MPa)	ISO 294-4	1.10 ÷ 1.40	%	
Transversal (2.0mm/60MPa)	ISO 294-4	1.05 ÷ 1.35	%	
MECHANICAL PROPERTIES	STANDARD	VALUE	MEASURE	UNITS
CHARPY impact strength				
Unnotched, at +23°C	ISO 179-1eU	10.0	kJ/m ²	
Notched, at +23°C	ISO 179-1eA	1.2	kJ/m ²	
Tensile elongation				
At break (5 mm/min), 23°C	ISO 527 (1)	2.0	%	
Tensile strength				
At break (5 mm/min), 23°C	ISO 527 (1)	50	MPa	
Elastic modulus				
Tensile (speed 1 mm/min), at 23°C	ISO 527 (1)	3400	MPa	

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THERMAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
VICAT - Softening point		
49 N (heating rate 50°C/h)	ISO 306	250 °C
HDT - Heat Deflection Temperature		
0.45 MN/m ²	ISO 75	240 °C
1.81 MN/m ²	ISO 75	90 °C

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MATERIAL - STORAGE

Sealed, undamaged packages has to be kept in dry storage facilities, providing they are also able to protect them from weather and accidental damage.

HANDLING AND SAFETY

Detailed information about a safe treatment of the material are indicated in the "Material Safety Data Sheet" (MSDS) furnished with the first material supply. The MSDS may be also sent again in case of loss.

PREDRYING CONDITIONS

At least 3 hours at $80 \div 100^{\circ}\text{C}$

These are the suggested conditions to reduce the moisture content to adequate levels. Temperature and drying time can be reduced by using vacuum ovens. Particularly wet material may need a longer drying time.

ACTUAL MELT TEMPERATURE

$270 \div 290^{\circ}\text{C}$

The injection moulding machine settings needed to obtain the suggested melt temperature will depend greatly on shot size and machine capacity, as well as other moulding parameters such as: injection speed, screw RPM, back pressure, etc. On small machines, running short cycles, it is possible to use higher melt temperatures to improve plastification, fluidity and surface appearance, paying attention to any indication of material degradation.

MOULD TEMPERATURE

$70 \div 90^{\circ}\text{C}$

The mould temperature suggested above is the actual tool steel temperature. This can be significantly different from the tool settings, due to the cooling system efficiency and the accuracy of the temperature control on the tool.

INJECTION SPEED

Medium

The advisable injection speed greatly depends on cavity geometry and injection moulding machine size. The use of high injection speed can improve the surface appearance, but it can also cause outgassing and burn marks due to overheating through shear stress.

REGRIND USAGE

The use of regrind is possible, but should be assessed on the basis of the project, moulding parameters, and type of grinding used. The effect of using regrind on material properties must be evaluated by the customer on its specific project and process. High percentages of regrind may cause a reduction in viscosity, reducing mechanical properties, first resilience.

HOT RUNNER MOULDS

Hot runner moulds may be used when a very tight temperature control is assured.

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TO AVOID

In order to prevent any material degradation, over-dimensioned machines should be avoided.

EQUIPMENT WEAR

Usually, critical processing conditions (high injection rate, high back pressure and high screw rotating speed, etc.) and/or disadvantageous geometric conditions (low wall thickness, low diameters, sharp fillet radius, etc.) generate wear on equipment. Wear increases in case of filled materials (particularly fibre filled ones). Appropriate equipment surface treatments are suggested in these cases, as well as a proper venting to avoid material overheating.

NOTES

The products mentioned herein are not suitable for applications in contact with foodstuff or for potable water transportation, or for toy manufacturing. The products mentioned herein are not suitable for applications in the pharmaceutical, medical or dental sector.

CONTACTS

LATI Industria Termoplastici S.p.A.