LATI HIGH PERFORMANCE THERMOPLASTICS

LATIOHM 66-08 PD02 G/35

Dissipative compound based on Polyamide 66 (PA 66).
Glass fibres.

PHYSICAL PROPERTIES - Typical values	STANDARD	VALUE	MEASURE UNITS
Density	ISO 1183	1.44	g/cm³
Linear shrinkage at moulding - 0.078 in thickness (at 8,700 psi of cavity pressure)			
Longitudinal	ISO 294-4	0.004 ÷ 0.006	in/in
Transversal	ISO 294-4	0.010 ÷ 0.012	in/in
MECHANICAL PROPERTIES - Typical values			
IZOD impact strength (sample 2.5x0.5x0.125 in)			
Notched, at +73°F	ASTM D256-A	1.17	ft.lb/in
CHARPY impact strength (sample 3.149x0.393x0.157 in)			
Unnotched, at +73°F	ISO 179-1eU	25.70	ft.lb/in²
Notched, at +73°F	ISO 179-1eA	3.74	ft.lb/in²
Tensile elongation (speed 0.196 in/min)			
At break, 73°F	ISO 527 (1)	4	%
Tensile strength (speed 0.196 in/min)			
At break, 73°F	ISO 527 (1)	13,100	psi
Elastic modulus			
Tensile (speed 0.04 in/min), at 73°F	ISO 527 (1)	1,146	kpsi

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THERMAL PROPERTIES - Typical values	STANDARD	VALUE	MEASURE UNITS
VICAT - Softening point			
2,2 lb (heating rate 11°F/h)	ISO 306	446	°F
HDT - Heat Deflection Temperature			
66 psi	ISO 75	482	°F
264 psi	ISO 75	410	°F
ELECTRICAL PROPERTIES - Typical values			
Electrical resistivity			
Surface	ASTM D 257	1E8	ohm
Volume	ASTM D 257	6E8	ohm.cm

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PREDRYING CONDITIONS — At least 3 hours at 195 ÷ 210°F

These are the suggested conditions to reduce the moisture content to adequate levels. Temperature and drying time are reduced when using vacuum ovens. A particularly wet material may need longer drying time.

ACTUAL MELT TEMPERATURE — 525 ÷ 570°F

The injection machine settings needed to obtain the suggested melt temperature will depend greatly on shot size and machine capacity, as well as other molding 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.

MOLD TEMPERATURE — 175 ÷ 210°F

The mold temperature suggested above is the actual 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 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. The effect of using regrind on material properties must be evaluated by the customer on its specific project and process. High percentages of regrind can cause a reduction in viscosity and fibre length, reducing mechanical properties, reducing mechanical properties

HOT RUNNER MOULDS

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

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TO AVOID

Shut-off nozzles and internally heated hot runners have to be avoided. In order to prevent any material degradation, over-dimensioned machines should be avoided.

CONTACTS

LATI Industria Termoplastici S.p.A.