

LATISHIELD 66-10A

EMI shielding product based on Polyamide 66 (PA66).
Steel fibers.

PHYSICAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
Density	ISO 1183	1.24 g/cm ³
Linear shrinkage at moulding		
Longitudinal (0.078in/8,700psi)	ISO 294-4	0.012 ÷ 0.015 in/in
Transversal (0.078in/8,700psi)	ISO 294-4	0.012 ÷ 0.015 in/in
MECHANICAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
CHARPY impact strength		
Unnotched, at +73°F	ISO 179-1eU	16.36 ft.lb/in ²
Notched, at +73°F	ISO 179-1eA	1.54 ft.lb/in ²
Tensile elongation		
At yield (0.196 in/min), 73°F	ISO 527 (1)	3.0 %
At break (0.196 in/min), 73°F	ISO 527 (1)	7.5 %
Tensile strength		
At break (0.196 in/min), 73°F	ISO 527 (1)	4400 psi
Elastic modulus		
Tensile (speed 0.04 in/min), at 73°F	ISO 527 (1)	550 kpsi

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THERMAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
VICAT - Softening point		
11 lb (heating rate 122°F/h)	ISO 306	446 °F
HDT - Heat Deflection Temperature		
66 psi	ISO 75	419 °F
264 psi	ISO 75	167 °F
ELECTRICAL PROPERTIES	STANDARD	VALUE MEASURE UNITS
Electrical resistivity		
Surface	ASTM D 257	1E1 ohm
Volume	ASTM D 257	1E2 ohm.cm
Electromagnetic reflection		
(Bekiscan - CP)	---	96 %

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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 damages.

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

Predrying not necessary

. Particularly wet material may need a longer drying time.

ACTUAL MELT TEMPERATURE

446 ÷ 482°F

The injection molding 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

158 ÷ 212°F

The mold 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. The best results can be obtained keeping the tool temperature in the upper range.

INJECTION SPEED

Low to medium

The advisable injection speed greatly depends on cavity geometry and injection molding machine size. The use of high injection speed should be avoided as it can cause excessive shear stress on the steel fibres, reducing their EMI shielding effectiveness.

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, especially when high shielding is required. High percentages of regrind may cause a reduction in viscosity and fibre length, reducing mechanical properties and EMI shielding effectiveness. The use of regrind shall be avoided when the shielding requirements for the application are close to the maximum attainable with the product.

HOT RUNNER MOLDS AND SUB GATES

Hot runner molds and/or small injection gates are not recommended and their use should be evaluated with the support of LATI technical service. To avoid the risk of clogging small pin and submarine gates, as well as hot drops, it is necessary to start every molding session by molding a few parts with a standard, glass reinforced, . LATISHIELD must be added to the standard material in the hopper without purging the barrel and keeping high back pressure until a few parts are molded showing good dispersion of the steel fibres. The specific procedure should be set up with the help if LATI technical service. It must be noted that pin and submarine gates cause high shear stress and can negatively affect the shielding properties of the material..

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MATERIAL HANDLING

Pneumatic conveyor systems shall be avoided to prevent the separation of the steel bundles from the base resin.

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.

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.