

## LATAMID 12 H FE90

Polyamide 12 (PA12) based compound.  
Heat stabilized. Magnetizable filler.

| PHYSICAL PROPERTIES                  | STANDARD    | VALUE         | MEASURE               | UNITS |
|--------------------------------------|-------------|---------------|-----------------------|-------|
| Density                              | ISO 1183    | 3.27          | g/cm <sup>3</sup>     |       |
| Linear shrinkage at moulding         |             |               |                       |       |
| Longitudinal (0.078in/8,700psi)      | ISO 294-4   | 0.007 ÷ 0.009 | in/in                 |       |
| Transversal (0.078in/8,700psi)       | ISO 294-4   | 0.007 ÷ 0.009 | in/in                 |       |
| Moisture absorption (in air)         |             |               |                       |       |
| after 24hrs                          | ISO 62-4    | 0.04          | %                     |       |
| MECHANICAL PROPERTIES                | STANDARD    | VALUE         | MEASURE               | UNITS |
| CHARPY impact strength               |             |               |                       |       |
| Unnotched, at +73°F                  | ISO 179-1eU | 4.67          | ft.lb/in <sup>2</sup> |       |
| Notched, at +73°F                    | ISO 179-1eA | 0.93          | ft.lb/in <sup>2</sup> |       |
| Tensile elongation                   |             |               |                       |       |
| At break (0.196 in/min), 73°F        | ISO 527 (1) | 1.0           | %                     |       |
| Tensile strength                     |             |               |                       |       |
| At break (0.196 in/min), 73°F        | ISO 527 (1) | 5100          | psi                   |       |
| Elastic modulus                      |             |               |                       |       |
| Tensile (speed 0.04 in/min), at 73°F | ISO 527 (1) | 1300          | kpsi                  |       |

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| THERMAL PROPERTIES                                    | STANDARD         | VALUE MEASURE UNITS |
|-------------------------------------------------------|------------------|---------------------|
| <b>Coefficient of linear thermal expansion (CLTE)</b> |                  |                     |
| +86°C to +212°F (longitudinal)                        | ISO 11359-2      | 67 µin/(in·°F)      |
| <b>VICAT - Softening point</b>                        |                  |                     |
| 11 lb (heating rate 122°F/h)                          | ISO 306          | 320 °F              |
| <b>HDT - Heat Deflection Temperature</b>              |                  |                     |
| 66 psi                                                | ISO 75           | 302 °F              |
| 264 psi                                               | ISO 75           | 203 °F              |
| <b>C.U.T. - Continuous Use Temperature</b>            |                  |                     |
| Long period (20,000h)                                 | ASTM E1641/E1877 | 230 °F              |
| FLAMMABILITY                                          | STANDARD         | VALUE MEASURE UNITS |
| <b>Flammability rating</b>                            |                  |                     |
| 0.118 in thickness                                    | UL 94            | HB                  |
| 0.059 in thickness                                    | UL 94            | HB                  |
| 0.029 in thickness                                    | UL 94            | HB                  |
| MAGNETIC PROPERTIES                                   | STANDARD         | VALUE MEASURE UNITS |
| Remanence (Br) @ 70°F                                 | ---              | 125.0 A/mm          |
| Coercivity (BHc - HcB) @ 70°F                         | ---              | 95 A/mm             |
| Intrinsic Coercivity (IHc - HcJ) @ 70°F               | ---              | 250 kA/m            |
| Energy density ( (BH) max ) @ 70°C                    | ---              | 3 kJ/m <sup>3</sup> |

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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

At least 3 hours at 158 ÷ 194°F

These are the suggested conditions to reduce the moisture content to adequate levels. Temperature and drying time can be reduced by using vacuum ovens

### ACTUAL MELT TEMPERATURE

482 ÷ 518°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 ÷ 194°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.

### INJECTION SPEED

Medium

The advisable injection speed greatly depends on cavity geometry and injection molding 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. According to UL guideline, up to 25% of regrind is permitted, without affecting the ratings of the yellow card. However, LATI suggests that no more of 15% of regrind is used.

### HOT RUNNER MOLDS

Hot runner moulds are not recommended, but they may be used when a very tight temperature control is assured, overall in the gate(s), and the cycle time is short.

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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.

### 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.**

### APPROVALS

USA (UL): Product versions approved according UL recommendations are available.