Heramid® A NER MP/1 K

Radici Group High Performance Polymers - Polyamide 66

General Information

Product Description

PA66 injection moulding grade. Toughened, heat stabilizaed. Black colour.

Post-industrial grade produced with selected polymers coming from polymerization, fibres and compounding plants.

General		
Additive	• Impact Modifier	
Recycled Content	• Post-Industrial (PIR)/Pre-Consumer	
Features	• Good Toughness	• Heat Stabilized
Uses	• Automotive Applications	
Agency Ratings	• EU 2011/65/EC	
RoHS Compliance	• RoHS Compliant	
Appearance	• Black	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA66-IT	

Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.12	--	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/1.0 kg	8.0	--	g/10 min	
Molding Shrinkage [2]				ISO 294-4
Across Flow	1.5	--	%	
Flow	1.4	--	%	
Water Absorption				ISO 62
Saturation, 73°F, 0.0787 in	7.5	--	%	
Water Absorption				ISO 62
Equilibrium, 73°F, 0.0787 in, 50% RH	2.5	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	348000	218000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	8700	6530	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	6.0	--	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	33	--	%	ISO 527-2/1A/50
Flexural Modulus [3]	319000	--	psi	ISO 178
Flexural Stress [3]	13100	--	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
73°F	6.2 ft·lb/in²	No Break		
Charpy Unnotched Impact Strength				ISO 179/1eU
73°F	No Break	No Break		
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				ISO 75-2/Bf
66 psi, Unannealed	347	--	°F	

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Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/Af
264 psi, Unannealed	149	--	°F	
Melting Temperature [4]	500	--	°F	ISO 11357-3
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate (0.118 in)	< 3.9	--	in/min	ISO 3795
Flame Rating (0.031 in)	HB	--		UL 94

Processing Information

Injection	Dry	Unit
Drying Temperature - Desiccant Dryer	176	°F
Drying Time - Desiccant Dryer	2.0 to 4.0	hr
Dew Point - Desiccant Dryer	< -4	°F
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	518 to 554	°F
Mold Temperature	158 to 176	°F
Injection Rate	Moderate-Fast	

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 290°C Melt Temperature, 70°C Mold Temperature, 60 MPa Cavity Pressure

[3] 0.079 in/min

[4] 10°C/min