

PRODUCT INFORMATION

HERAMID A NER MP/1 K

DESCRIPTION

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

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

ISO 1043: PA66-IT

REGIONAL AVAILABILITY: Europe

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

Injection Molding Processing Parameters

Melt Temperature
270 - 290°C

Mold Temperature
80 - 90°C

Injection Speed
medium-high

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet
ROHS compliant 2011/65/UE and following amendments

TECHNICAL DATA SHEET

HERAMID A NER MP/1 K

PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
PHYSICAL PROPERTIES				
Density	ISO 1183	kg/m ³	1120	
Moulding shrinkage - Parallel / Normal	ISO 294-4	%	1.4 / 1.5	
Water Absorption, immersion at 23°C	ISO 62	%	7.5	
Moisture Absorption 23°C - 50%RH	ISO 62	%	2.5	
MECHANICAL PROPERTIES				
Tensile Modulus	ISO 527-2/1A	MPa	2400	1500
Stress at Yield	ISO 527-2/1A	MPa	60	45
Stress at Break	ISO 527-2/1A	MPa	53	40
Flexural Modulus	ISO 178	MPa	2200	
Flexural Strength	ISO 178	MPa	90	
Charpy Impact Strength	ISO 179/1eU	kJ/m ²	N	0
Charpy Notched Impact Strength	ISO 179/1eA	kJ/m ²	13	N
THERMAL PROPERTIES				
Melting Temperature	ISO 11357-1/-3	°C	260	
Heat Deflection Temperature	ISO 75/2Af	°C	66	
Heat Deflection Temperature	ISO 75/2Bf	°C	175	
FLAMMABILITY PROPERTIES				
Flammability	UL 94	class	HB	
Automotive Interior Flammability	ISO 3795	mm/min	<100	

*: DAM = Dry As Moulded state according to ISO 16396-2 **: Cond = Conditioned state similar to ISO 1110 1: Melt Temperature [°C] / Mold Temperature [°C] / Cavity Pressure [MPa]