

HERAMID A NER MP/1K

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

MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more.

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.

Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
270 ÷ 290 °C	80 ÷ 90 °C	Medium-High

PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2002/95/CE and following amendments

Technical data sheet

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PROPERTY		STANDARD	UNIT	VALUE	
				DAM*	Cond**
Physical Properties					
Density		ISO 1183	Kg/m ³	1120	
Moulding shrinkage – Parallel / Normal	290/70/60***	ISO 294-4	%	1,4 / 1,5	
Moisture absorption 23°C – 50%RH	2mm thk	ISO 62	%	2,5	
Water absorption, immersion at 23°C	2mm thk	ISO 62	%	7,5	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	2400	1500
Stress at Break	5mm/min	ISO 527-2/1A	MPa	53	40
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	60	45
Yield Strain	50mm/min	ISO 527-2/1A	%	5	30
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	30	70
Flexural Modulus	2mm/min	ISO 178	MPa	2200	
Flexural Strength	2mm/min	ISO 178	MPa	85	
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m ²	NB	NB
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m ²	13	NB
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	260	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	66	
Flammability Properties					
Flammability	0.8mm	UL 94	class	HB	

*DAM = Dry As Moulded state **Cond = Conditioned state similar to ISO 1110 ***Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]