



Document	ISO Datasheet
Description	PA 66
Grade	DAFNEMID 66A T04
Code	
Application	Injection moulding

Very good processability, good heat resistance and mechanical properties. Lubricated.

Properties	Method	Unit	Value
<b>Physical</b>			
Density at 23°C	ISO 1183	g/cm <sup>3</sup>	1,26
Mould Shrinkage (%)	INTERNAL	%	1,5-1,9
<b>Thermal</b>			
Vicat B50	ISO 306	°C	240
Ball Pressure Test	IEC 60695-10-2	°C	165
HDT, A (1.80 MPa)	ISO 75/Af	°C	75
HDT, B (0.45 MPa)	ISO 75/Af	°C	230
<b>Mechanical at 23 °C</b>			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	2800
Flexural strenght (23°C - 2 mm/min)	ISO 178	MPa	100
Tensile stress at break (23°C-5 mm/min)	ISO 527-2	MPa	65
Tensile elong. at break (23°C-5 mm/min)	ISO 527-2	%	10
Rockwell hardness (L scale)	ISO 2039-2		80
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m <sup>2</sup>	4
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m <sup>2</sup>	4
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m <sup>2</sup>	50
<b>Flammability</b>			
Glow Wire Flammability Index GWFI (1,0 mm)	IEC 60695-2-12	°C	700
Glow Wire Flammability Index GWFI (3,0 mm)	IEC 60695-2-12	°C	700
Glow Wire Ignition Temperature GWIT (1,0 mm)	IEC 60695-2-13	°C	675
Glow Wire Ignition Temperature GWIT (3,0 mm)	IEC 60695-2-13	°C	675
Flammability class (0,8 mm)	UL94		HB
Flammability class (1,6 mm)	UL94		HB

Processing Conditions			
Melt Temperature Range	ISO 294	°C	270-300
Mold Temperature Range	ISO 294	°C	70-90
Injection Velocity	ISO 294		MEDIUM
Drying Temperature		°C	80-100
Drying Time		Hour	3
Regulations compliance			
RoHS compliance status:	COMPLIANT		
EN71:			
UL listed file n°:			
Water contact approvals.			
Food contact status:			

§ Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 4.0 x 10.0 x 170 mm sample.

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