

DOMAMID® 66/6IK1H2 BK

(DOMAMID A3-513-I1-H2-B)

Polyamide 66/6, low temperature impact modified, heat stabilized, for injection moulding, black

preliminary datasheet

24.02.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,12
Moisture absorption	sat., 23°C, 50% RH	ISO 62	[%]	2,5
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,65 - 1,85
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,60 - 1,80
RHEOLOGICAL				
Melt Volume Rate (MVR)		ISO 1133	[cm ³ /10 min]	90-150
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	2700 / 1900
Tensile stress at break	50 mm/min	ISO 527	[MPa]	45 / 39
Tensile strain at break	50 mm/min	ISO 527	[%]	18 / 50
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	70 / 45
Tensile strain at yield	50 mm/min	ISO 527	[%]	4 / 20
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	N / N
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	10 / 13
THERMAL				
Melting point		ISO 11357-1	[°C]	262
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	167
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	52

Test run at 23°C if not differently specified, DAM state (dry as moulded).

PROCESSING CONDITIONS:

Drying temperature/time : 75-85°C / 2-4h (with dew point of dried air < -30 °C)
 Recommended melt temperature : 240-280 °C
 Recommended mould temperature : 60-80 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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