

# PA66IMF40



## Product Description

Nylon 66

## Special Characteristics

- 40% Glass/Mineral Filled Nylon 66

## General Properties

Appearance	Black, Natural or Colors
Processing Methods	Injection Molding
Applications	Automotive, Material Handling, Industrial

## Mechanical Properties

	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	19,000	psi	131	MPa
Tensile Strength @ Break	ASTM D638	7,830	psi	54	MPa
Tensile Elongation at Break	ASTM D638	3	%	3	%
Flexural Modulus	ASTM D790	1,100,000	psi	7,586	MPa
Flexural Strength	ASTM D790	30,000	psi	207	MPa
Notched Izod Impact (73°F)	ASTM D256	1.0	ft-lb/in	53	J/m

## Physical Properties

	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.46	sp gr	1.46	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.004	in/in	0.102	mm/mm
Filler Content		40	%	40	%

## Thermal Properties

	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	428	°F	220	°C

## Injection Molding

	Value	
Drying Temperature	180	°F
Drying Time	2.0 - 4.0	hrs
Maximum Drying Time	4.0	hrs
Suggested Maximum Moisture	0.02	%
Rear Barrel Temperatures	550 - 590	°F
Middle Barrel Temperatures	540 - 560	°F
Front Barrel Temperatures	520 - 540	°F
Nozzle Temperature	510 - 560	°F
Melt (processing) Temperatures	540 - 560	°F
Mold Temperatures	150 - 200	°F
Back Pressure	50	psi
Screw speed	30 - 120	rpm

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These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.

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