

Technical Datasheet

Material Type	PA66	Trademark	Ecolon®	Grade Name	MRGF1945-BK2
Feature			<ul style="list-style-type: none"> (PA66) 		
Material Standard			<ul style="list-style-type: none"> XXXXXX 		
Availability			<ul style="list-style-type: none"> Asian-Pacific, America 		
Processing method			<ul style="list-style-type: none"> Injection Molding 		
Appearance			<ul style="list-style-type: none"> Color is Optional 		
Applications			<ul style="list-style-type: none"> Automotive and Engineering parts 		

General Properties

No.	Properties	Unit	Typical Value	Method	Test condition
1	Filler Content	%	40	ISO 3451-1, -4	
2	Density	g/mL	1.49	ISO 1183	23 °C
3	Melt Point	°C	260	ISO 3146	DSC
4	Tensile Strength	MPa	118	ISO 527	5 mm/mm
5	Tensile Elongation	%	2.0	ISO 527	5 mm/mm
6	Flexural Strength	MPa	170	ISO 178	2 mm/mm
7	Flexural Modulus	MPa	9,300	ISO 178	2 mm/mm
8	Notched Charpy Impact	kJ/m ²	5.1	ISO 180	23 °C
9	Heat Deflection Temperature	°C	220	ISO 75	1.8 MPa
10	Material Shrinkage	%	0.3-0.7 (Flow)	ISO 294	23 °C, 48h
11	Material Shrinkage	%	0.8-1.2 (Cross)	ISO 294	23 °C, 48h

Processing Conditions

Drying condition	80 °C, 2-4 h
Molding Temp.	260 - 290 °C (F), 260 - 290 °C (M), 266 - 290 °C (B)
Melt Temp.	270 - 290 °C
Mold Temp.	70 - 90 °C
Screw Speed	30 - 120 rpm
Injection Pressure	30 - 140 MPa
Back Pressure	0.30 - 1.40 MPa

Notes: This technical data in the product brochures are typical test results for reference, and should not be defined as minimum value.