

Wellman Wellamid® MR409 22H-N 40% Mineral Reinforced Nylon 66, Heat Stabilized

Category : Polymer , Thermoplastic , Nylon , Nylon 66 , Nylon 66, 40% Mineral Filled

Material Notes:

Typical Applications: Lawn and garden equipment, automotive trim, bezels, wheel covers, window frames, gas tank filler housings, brackets, metalized lighting reflectors for automotive, automotive cooling fans & shrouds, automotive door handles, brackets, automotive mirror shells, painted parts, components for small gas engines, sporting goods, auto luggage rack components. Data provided by the manufacturer, Wellman Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Wellman-Wellamid-MR409-22H-N-40-Mineral-Reinforced-Nylon-66-Heat-Stabilized.php

Physical Properties	Metric	English	Comments
Density	1.46 g/cc	0.0527 lb/in ³	ISO 1183
Water Absorption	0.70 %	0.70 %	Approximate 24 hr.
Linear Mold Shrinkage	0.010 - 0.014 cm/cm	0.010 - 0.014 in/in	ISO 294-4

Mechanical Properties	Metric	English	Comments
Tensile Strength, Ultimate	85.0 MPa	12300 psi	ISO 527
Elongation at Break	6.0 %	6.0 %	ISO 527
Flexural Yield Strength	140 MPa	20300 psi	ISO 178
Flexural Modulus	5.70 GPa	827 ksi	ISO 178
Izod Impact, Notched	0.600 J/cm	1.12 ft-lb/in	ISO 180

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	100 °C	212 °F	ISO 75
Flammability, UL94	HB @Thickness 0.790 mm	HB @Thickness 0.0311 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	282 - 304 °C	540 - 580 °F	
Middle Barrel Temperature	277 - 299 °C	530 - 570 °F	
Front Barrel Temperature	271 - 293 °C	520 - 560 °F	
Nozzle Temperature	282 - 293 °C	540 - 560 °F	

Processing Properties	Metric	English	Comments
Mold Temperature	71.1 - 93.3 °C	160 - 200 °F	
Drying Temperature	79.4 °C	175 °F	Opened bags and gaylord boxes
Dry Time	2 - 4 hour	2 - 4 hour	Opened bags and gaylord boxes
Moisture Content	0.050 - 0.20 %	0.050 - 0.20 %	During molding to prevent hydrolytic degradation
	<= 0.20 %	<= 0.20 %	In shipping bags, ready to mold
Injection Pressure	34.5 - 138 MPa	5000 - 20000 psi	
Back Pressure	0.345 MPa	50.0 psi	
Screw Speed	30 - 120 rpm	30 - 120 rpm	

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