

Ultramid® 1503-2 NF2004

Polyamide 66



Product Description

Ultramid 1503-2 NF2004 is a 33% glass reinforced, heat stabilized injection molding PA6/6.

PHYSICAL	ASTM Test Method	Property Value	
Specific Gravity	D-792	1.40	
Mold Shrinkage (1/8" bar, in/in)		0.003	
Moisture, %	D-570		
(50% RH)		1.7	
(Saturation)		5.7	
MECHANICAL	ASTM Test Method	Dry	Conditioned
Tensile Strength, Break, MPa (psi)	D-638		
23C (73F)		193 (28,000)	-
Elongation, Break, %	D-638		
23C (73F)		3	-
Flexural Modulus, MPa (psi)	D-790		
23C (73F)		8,280 (1,200,000)	-
Flexural Strength, MPa (psi)	D-790		
23C (73F)		276 (40,000)	-
IMPACT	ASTM Test Method	Dry	Conditioned
Notched Izod Impact, J/M (ft-lbs/in)	D-256		
23C (73F)		117 (2.2)	-
THERMAL	ASTM Test Method	Dry	Conditioned
Melting Point, C(F)	D-3418	260 (500)	-
Heat Deflection @ 264 psi (1.8 MPa) C(F)	D-648	252 (485)	-
Heat Deflection @ 66 psi (.45 MPa) C(F)	D-648	297 (566)	-

Processing Guidelines

Material Handling

Nylon 66 materials must be properly dried in order to provide parts with optimum strength and toughness. Nylon 66 materials are hygroscopic and will become degraded by excessive moisture during the injection molding process. For unopened bag/box, dry at 60 degC (140 degF) for 1-2 hours. For material exposed to the atmosphere, if additional drying is needed, dry at 66 degC (150 degF) or until the moisture level is between 0.04 - 0.20%.

Typical Profile

Melt Temperature: 288-305 degC (550-581 degF)

Mold Temperature: 60-100 degC (140-212 degF)

Injection Pressure: 35-125 MPa (5000-18000 psi)

Back Pressure: 0-0.35 MPa (0-50 psi)

Screw RPM 40-80

Screw Compression Ratio: 3:1-4:1

Mold Temperatures



This product can be processed over a wide range of mold temperatures; however, for applications where aesthetics are critical, a mold surface temperature of 60-100 degC (140-212 degF) is recommended.

Pressures

Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off.

Fill Rate

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing.

Note

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