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AVP® GYYHS
GE Polymerland - Polyamide 66

Friday, December 08, 2006

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Test Standards Available	• ASTM
Additive	• Heat Stabilizer • Lubricant • UV Stabilizer
Features	• Heat Stabilized • Lubricated • UV Resistance, Good
Forms	• Pellets
Processing Method	• Injection Molding

ASTM and ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density -Specific Gravity	1.14	sp gr 23/23°C	ASTM D792
Mold Shrink, Linear-Flow	0.013 to 0.015	in/in	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength,Ultimate [2]	11500	psi	ASTM D638
Flexural Modulus (2.00 in Span) [3]	360000	psi	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73 °F, 0.125 in) [4]	0.800	ft-lb/in	ASTM D256

Thermal	Nominal Value	Unit	Test Method
DTUL @264psi - Unannealed (0.250 in)	170	°F	ASTM D648
Melting Point	480	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0	hr
Drying Time, Maximum	8.0	hr
Suggested Shot Size	40 to 80	%
Rear Temperature	480 to 540	°F
Middle Temperature	500 to 550	°F
Front Temperature	520 to 580	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	520 to 580	°F
Mold Temperature	150 to 230	°F
Back Pressure	25.0 to 150	psi
Screw Speed	50 to 150	rpm

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 2.0 in/min, 0.125 in

[3] 0.050 in/min, 0.125 in

[4] Method A