

Preliminary Data Sheet

Product Description

Polyamide 66 – Glass Filled + Glass beads (30%) , FDA Grade

Product Applications

Appliances: Food contact applications like - Cutlery, Plates etc.

General

Material Status	<ul style="list-style-type: none"> Commercial : Active
Filler/Reinforcement	<ul style="list-style-type: none"> 30 % Glass filled + Glass beads
Forms	<ul style="list-style-type: none"> Pellets
Additive	<ul style="list-style-type: none"> Mold Release
RoHS Compliance	<ul style="list-style-type: none"> ROHS compliant
Features	<ul style="list-style-type: none"> Non FR , Good Dimensional stability
Appearance/Color	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection molding

Physical	Typical Value	Unit	Test Method
Specific Gravity	1.36	g/cc	ISO 1183
Melt Flow Index 275/1.2 Kg	11	G/10Min	ISO 1133
Mold Shrinkage			
Flow Direction	0.3 – 0.6	%	ISO 294-4
Cross Flow Direction	0.8 – 1.0		

Mechanical	Typical Value	Unit	Test Method
Tensile Stress at Break	138	MPa	ISO 527
Tensile Strain at Break	3.8	%	ISO 527
Tensile Modulus	8100	MPa	ISO 527
Flexural Strength	209	MPa	ISO 178
IZOD Impact Strength			
Notch	5.3	KJ/M ²	ISO 180/1A
Unnotch	45	KJ/M ²	ISO 180/1U

Thermal	Typical Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa Unannealed	230	°C	ISO 75
1.8 MPa Unannealed	220	°C	
Melting Point	260	°C	DSC

Flammability	Typical Value	Unit	Test Method
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Flammability Classification 1.5 mm	HB	Rating	UL-94
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Injection Molding – XU6730BB11FD**Drying Conditions**

Drying Time(hour)	Temperature	Remarks
3-4	80-90°C	Increase Temperature 10-20 °C or Drying time 1-2 hrs if required. Moisture content after drying should be <0.2% Avoid sudden cooling of dry pellet

Injection Molding Temperatures (°C)

Mold	Melt	Nozzle	Centre	Feed zone
60 – 80	285– 295	285 -295	280 - 290	265-275

Physical form and storage

ESTOPLAST XU is supplied in pellet form. It should be pre-dried as per the guideline mentioned above prior to molding. Standard packing size is 25kg. In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged.

Product Safety

ESTOPLAST XU is thermally stable up to 330°C and does not give rise to hazardous material due to degradation or evolution of gases and vapors. ESTOPLAST XU decomposes above 380°C and gives carbon dioxide and water on charring.

For more information on safety, refer individual product MSDS. Available on request.

Note

All information supplied in this publication is based on our current knowledge and experience. The data provided fall within the normal range of product properties and relate only to the specific material designed. The data provided should not be used to establish specification limits or used alone as the basis of design. ESTER assumes no liability and makes no warranties of any kind, expressed or implied, whatsoever in respect of application, processing or use made of aforementioned information or product.