



Technical Data Sheet

Grade

MWR PA66 4220HS

Product Description:

Polyamide (nylon) 66 High Impact Heat Stabilized

Physical Properties	Method	English	SI
Density	ISO 1183	-	1.080 g/cm ³
Melt Point	D 789	503 F	262 C
Linear Mold Shrinkage With Flow (Typical)	D 955	0.018 in/in	0.018 mm/mm
Linear Mold Shrinkage Across Flow (Typical)	D 955	0.014 in/in	0.014 mm/mm

Mechanical Properties	Method	English	SI
Tensile Strength at Yield	ISO 527	-	52.0 Mpa
Tensile Elongation at Yield	ISO 527	-	4.0 %
Flexural Modulus	ISO 178	-	1900 Mpa
Izod Impact (notched)	ISO 180	-	75.0 kJ/m ²

Thermal Properties	Method	English	SI
Heat Deflection Temperature at 0.45 Mpa	ISO 75-2	-	157 C
Heat Deflection Temperature at 1.8 Mpa	ISO 75-2	-	62 C

Processing (Injection Molding)	English	SI
Drying Temperature	175 F	79 C
Drying Time	4 hrs	4 hrs
Max Moisture Content	0.20 %	0.20 %
Rear Barrel Temperature	540 F	282 C
Middle Barrel Temperature	550 F	288 C
Front Barrel Temperature	560 F	293 C
Nozzle Temperature	560 F	293 C
Stock Temperature	560 F	293 C
Mold Temperature	175 F	79 C

Comments:

All properties tested using dry as molded specimens.

Values shown are averages and not to be construed as specifications.

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