

PRODUCT SPECIFICATIONS



TUFNYL®

Resin Type: Polyamide 66

RB30W1BLACK

Common features of Tufnyl® Polyamide resin include excellent mechanical and physical properties such as high mechanical strength, excellent balance of stiffness and toughness, good high temperature performance, good electrical properties, abrasion and chemical resistance.

Polyamide 66 30% glass fiber reinforced, heat resistant material in black for injection molding applications.

Property	Unit	Testing Method	Typical Data (DAM)
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MECHANICAL PROPERTIES

Tensile strength @ break	MPa	ISO 527	185
Elongation @ break	%	ISO 527	4
Flexural modulus	MPa	ISO 178	9000
Flexural strength	MPa	ISO 178	280
Rockwell hardness	R- Scale	ISO 2039-2	115
Rockwell hardness	M- Scale	ISO 2039-2	90
Izod notched impact strength (+23 C)	KJ/m ²	ISO 180	11

THERMAL PROPERTIES

Heat deflection temp. @ 1.82 Mpa load	°C	ISO 75	250
Melting Point	°C	ISO 11357	260

PHYSICAL PROPERTIES

Density	kg/m ³	ISO 1183	1360
Moisture content	%	DSM	0.20 MAX

PROCESSING GUIDELINES

Parameter	Unit	Typical Data
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PRE-DRYING SETTINGS

Pre-Drying Temperature	°C	Vacuum/Air Circulated Ovens at 100/80
Pre-Drying Time	Hours	2-4 hrs

It is recommended to pre-dry the material granules in vacuum / air circulated ovens using perforated trays.

INJECTION MOLDING SETTINGS

Mold Temperature	°C	80-100
Nozzle Temperature	°C	300
Melting Zone Temperature	°C	290-295
Compression Zone Temperature	°C	285-290
Feed Zone Temperature	°C	270-280

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