

**Witcom PA66/4L1**

(PA66+PTFE)

Wittenburg B.V.

**Product Texts**

20% PTFE

**Processing/Physical Characteristics****ISO Data**

	Value	Unit	Test Standard
Molding shrinkage, parallel	1.6	%	ISO 294-4, 2577

**Mechanical properties****ISO Data**

	Value	Unit	Test Standard
Tensile Strength	70	MPa	ISO 527
Strain at break	8	%	ISO 527
Flexural modulus, 23°C	2800	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Izod impact strength, +23°C	75	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	5.5	kJ/m <sup>2</sup>	ISO 180/1A

**Thermal properties****ISO Data**

	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	80	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	80	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.6	mm	-
Glow Wire Ignition Temperature (GWIT)	650	°C	IEC 60695-2-13
GWIT - thickness tested (1)	1.6	mm	-

**Electrical properties****ASTM Data**

	Value	Unit	Test Standard
Surface Resistivity	1E12	Ohm	ASTM D 257

**Other properties**

	Value	Unit	Test Standard
Water absorption	6.8	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1250	kg/m <sup>3</sup>	ISO 1183

**Processing Recommendation Injection Molding**

	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	3 - 5	h	-
Processing humidity	≤0.1	%	-
Melt temperature	275 - 295	°C	-
Mold temperature	60 - 95	°C	-
Back pressure	0 - 1	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe

**Additives**

Lubricants