



Phone: (248) 486-1449 Fax: (248) 486-7966

Technical Data Sheet

LCA® N66-408 HSL Type

Nylon 66 Medium Impact, Heat Stabilized, Lubricated

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties	English Units (ISO)	Metric Units	
Density	1.11 g/cm ³	1.11 g/cm ³	ASTM D-792 (ISO 1183)
Ash Content	%	0 %	ASTM D-5630
Linear Mold Shrinkage	in/in	mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched	4.00 ft-lb/in (kJ/m ²)	214 J/m	ASTM D-256 (ISO 108/1A)
Tensile Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-638 (ISO 527 - 1,2)
Tensile Strength @ Break	8,100 psi (Mpa)	56 MPa	ASTM D-638 (ISO 527 - 1,2)
Tensile Elongation @ Yield	%	0 %	ASTM D-638 (ISO 527 - 1,2)
Tensile Elongation @ Break	40 %	40 %	ASTM D-638 (ISO 527 - 1,2)
Flexural Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Modulus	330,000 psi (Mpa)	2,277 MPa	ASTM D-790 (ISO 178)
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648 (ISO 75 - 1,2)
@ 264 psi (1820 kPa)	Deg. F	Deg. C	ASTM D-648 (ISO 75 - 1,2)
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525 (ISO 306)
Melt Point	491 Deg. F	255 Deg. C	ASTM D-789-92e1

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions			
Process Variable	Description	Values	
Temperatures		F	C
Barrel	Rear	500 - 560	
	Center	510 - 560	
	Front	510 - 560	
	Nozzle	500 - 550	
	Mold	100 - 200	
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Drying			
Type		Dehumidifier	
Temperature		175°F	
Time		2 - 4 hours	
Max. % Moisture		0.2	
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Special Requirements			
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Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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