

Grade: PA66-1000N Black

Molding Grade PA 66

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.14	D792
Mechanical		
Tensile Strength @ Yield	11,200 psi	D638
Flexural Modulus	400,000 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	0.8 ft-lb/in	D256
Thermal		
Melting Temperature	496 °F	D3418

The information provided above is based upon typical values and are intended only as guides. Star Plastics, LLC, assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. *No guarantees or warranties are expressed or implied.*

*Orion® is a registered trademark of Star Plastics, LLC, its subsidiaries or affiliates.

Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2-6 hrs at 176-212°F
Suggested Max Moisture	<0.20%
Rear Temperature	482 – 536 °F
Middle Temperature	527 – 554 °F
Front Temperature	527 – 554 °F
Nozzle Temperature	527 – 563 °F
Processing (Melt) Temperature	500 – 580 °F
Mold Temperature	150 – 220 °F

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.