

## LATAMID 68 H2-V0

Compound based on PA6/PA66 copolymer.

Heat stabilised. UL94 V-0 classified, halogens and red phosphorous free. Product UL certified.

Good surface appearance.

PHYSICAL PROPERTIES - Typical values	STANDARD	VALUE MEASURE UNITS
Density	ISO 1183	1.16 g/cm <sup>3</sup>
<b>Linear shrinkage at moulding - 2.0 mm thickness (at 60 MPa of cavity pressure)</b>		
Longitudinal	ISO 294-4	0.85 ÷ 1.10 %
Transversal	ISO 294-4	0.60 ÷ 0.80 %
MECHANICAL PROPERTIES - Typical values		
<b>IZOD impact strength (sample 63.5x12.7x3.2 mm)</b>		
Notched, at +23°C	ASTM D 256-A	35 J/m
Notched, at -20°C	ASTM D256-A	25 J/m
<b>CHARPY impact strength (sample 80x10x4 mm)</b>		
Unnotched, at +23°C	ISO 179-1eU	90 kJ/m <sup>2</sup>
Unnotched, at -20°C	ISO 179-1eU	90 kJ/m <sup>2</sup>
Notched, at +23°C	ISO 179-1eA	3 kJ/m <sup>2</sup>
Notched, at -20°C	ISO 179-1eA	2.5 kJ/m <sup>2</sup>
<b>Tensile elongation (speed 5 mm/min)</b>		
At yield, 23°C	ISO 527 (1)	3 %
At yield, 60°C	ISO 527 (1)	- %
At yield, 90°C	ISO 527 (1)	- %
At yield, 120°C	ISO 527 (1)	- %
At yield, 150°C	ISO 527 (1)	- %
At break, 23°C	ISO 527 (1)	10 %
At break, 60°C	ISO 527 (1)	60 %
At break, 90°C	ISO 527 (1)	NB
At break, 120°C	ISO 527 (1)	NB
At break, 150°C	ISO 527 (1)	NB
<b>Tensile strength (speed 5 mm/min)</b>		
At yield, 23°C	ISO 527 (1)	75 MPa
At yield, 60°C	ISO 527 (1)	- MPa
At yield, 90°C	ISO 527 (1)	- MPa
At yield, 120°C	ISO 527 (1)	- MPa
At yield, 150°C	ISO 527 (1)	- MPa
At break, 23°C	ISO 527 (1)	70 MPa
At break, 60°C	ISO 527 (1)	45 MPa
At break, 90°C	ISO 527 (1)	NB
At break, 120°C	ISO 527 (1)	NB
At break, 150°C	ISO 527 (1)	NB
<b>Elastic modulus</b>		
Tensile (speed 1 mm/min), at 23°C	ISO 527 (1)	4300 MPa
Tensile (speed 1 mm/min), at 60°C	ISO 527 (1)	2000 MPa
Tensile (speed 1 mm/min), at 90°C	ISO 527 (1)	1100 MPa
Tensile (speed 1 mm/min), at 120°C	ISO 527 (1)	850 MPa
Tensile (speed 1 mm/min), at 150°C	ISO 527 (1)	650 MPa

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THERMAL PROPERTIES - Typical values	STANDARD	VALUE	MEASURE UNITS
<b>Coefficient of linear thermal expansion (CLTE)</b>			
+30°C to +100°C (longitudinal)	ASTM D 696	80	µm/(m·°C)
<b>VICAT - Softening point</b>			
49 N (heating rate 50°C/h)	ISO 306	210	°C
<b>HDT - Heat Deflection Temperature</b>			
0.45 MN/m <sup>2</sup>	ISO 75	205	°C
1.81 MN/m <sup>2</sup>	ISO 75	95	°C
<b>C.U.T. - Continuous Use Temperature (20,000h)</b>	---	100	°C
<b>FLAMMABILITY - Typical values</b>			
<b>Oxygen Index</b>	ASTM D 2863	30	%
<b>Flammability rating</b>			
3.00 mm thickness	UL 94	V-0 rating	
1.50 mm thickness	UL 94	V-0 rating	
0.75 mm thickness	UL 94	V-0 rating	
<b>GWFI - Glow Wire Flammability Index</b>			
	IEC 695-2-12	GWFI: 960/1.0mm	
	IEC 695-2-12	GWFI: 960/2.0mm	
<b>GWIT - Glow Wire Ignition Test</b>			
	IEC 695-2-13	GWIT: 750/1.0mm	
	IEC 695-2-13	GWIT: 700/2.0mm	
<b>ELECTRICAL PROPERTIES - Typical values</b>			
<b>CTI - Comparative Tracking Index</b>			
solution A (without surfactant)	IEC 112	600 V	

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### PREDRYING CONDITIONS

At least 3 hours at 90 ÷ 100°C

These are the suggested conditions to reduce the moisture content to adequate levels. Temperature and drying time are reduced when using vacuum ovens. A particularly wet material may need longer drying time.

### ACTUAL MELT TEMPERATURE

245 ÷ 255°C

The injection machine settings needed to obtain the suggested melt temperature will depend greatly on shot size and machine capacity, as well as other molding parameters such as: injection speed, screw RPM, back pressure, etc. On small machines, running short cycles, it is possible to use higher melt temperatures to improve plastification, fluidity and surface appearance, paying attention to any indication of material degradation.

### MOULD TEMPERATURE

70 ÷ 90°C

The mold temperature suggested above is the actual steel temperature. This can be significantly different from the tool settings, due to the cooling system efficiency and the accuracy of the temperature control on the tool.

### INJECTION SPEED

Medium

The advisable injection speed greatly depends on cavity geometry and injection machine size. The use of high injection speed can improve the surface appearance, but it can also cause outgassing and burn marks due to overheating through shear stress.

### REGRIND USAGE

The use of regrind is possible, but should be assessed on the basis of the project, moulding parameters, and type of grinding. The effect of using regrind on material properties must be evaluated by the customer on its specific project and process. High percentages of regrind can cause a reduction in viscosity, reducing mechanical properties, reducing mechanical properties

### HOT RUNNER MOULDS

Hot runner moulds are not recommended, but can be used when a very tight temperature control is assured and the cycle time is short.

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### TO AVOID

In order to prevent any material degradation, over-dimensioned machines should be avoided.

### CONTACTS

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### NOTES

**The products mentioned herein are not suitable for applications in contact with foodstuff or for potable water transportation, or for toy manufacturing. The products mentioned herein are not suitable for applications in the pharmaceutical, medical or dental sector.**

Values shown are based on testing of injection moulded laboratory test specimens, conditioned according to the practice and represent data that fall within the standard range of properties for non-coloured material, if not otherwise specified. As they may be subject to variations, these values do not represent a sufficient basis for any part design and are not intended for use in establishing values for specification purposes. Properties of moulded parts can be influenced by a wide range of factors including, but not limited to, colorants, part design, processing conditions, post-treatment conditions, environmental conditions and usage of regrind during the moulding process. If data are explicitly indicated as provisional, range of properties has to be considered wider. This information and technical assistance are provided as a convenience for informational purposes only and are subject to change without notice. The customer shall always ensure that the latest release of technical information is at his own disposal. Lati S.p.A. extends no warranties or guarantee, including a warranty of merchantability of whatever use is made of the product, and make no representations as to the accuracy, suitability, reliability, completeness and sufficiency of the information provided, and assume no responsibility regarding the consequences of its use or for any printing errors. It is the customer's responsibility to inspect and test our products in order to determine to his own satisfaction whether they are suitable for his intended uses and applications or used in conjunction with third-party materials. This application-specific analysis shall at least include preliminary testing to determine the suitability for the customer's particular purpose from a technical as well as health, safety, and environmental standpoint. Such testing has not necessarily been done by us as the manner in which the customer use and the purpose to which utilise our products are beyond our control. Lati S.p.A. does not accept and hereby disclaims liability for, any damages whatsoever in connection with the use of or reliance on this information. No one is authorised to make any warranties, issue any immunities or assume any liabilities on behalf of Lati S.p.A. except in a writing signed by a specifically authorised Lati S.p.A. executive. Unless otherwise agreed in writing, the exclusive remedy for all claims is replacement of the product or refund of the purchase price at Lati's option, and in no event shall Lati S.p.A. be liable for special, consequential, incidental, punitive or exemplary damages. No information herein can be considered as a suggestion to use any product in conflict with intellectual property rights of third-parties. Lati S.p.A. disclaims any liability that may be claimed for infringement or alleged infringement of patents. For any other issues Lati S.p.A. Conditions of Sales apply.  
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