

# Vydyne® M344

## polyamide 66/6 copolymer



Vydyne M344 is an halogenated, unfilled, flame-retardant PA66/6 copolymer designed with excellent strength and toughness. It is lubricated for machine feed and easy mold release and has an

Underwriters Laboratories UL 94 flammability classification of V-0 at 0.4 mm (0.016") thick.

General				
Material Status	• Commercial: Active			
Availability	• Asia Pacific	• Europe	• North America	
Additive	• Halogen	• Lubricant		
Features	• Ductile • Good Mold Release	• Halogenated • Ignition Resistant	• Low Density • Lubricated	
Uses	• Appliances • Automotive Electronics • Bobbins • Connectors • Electrical Housing	• Electrical Parts • Electrical/Electronic Applications • Fasteners • Industrial Applications • Lighting Applications	• Living Hinges • Printed Circuit Boards • Switches	
UL File Number	• E70062			
Appearance	• Natural Color			
Forms	• Pellets			
Processing Method	• Injection Molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.27	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 73°F, 0.0787 in	1.8	--	%	
Flow : 73°F, 0.0787 in	1.3	--	%	
Water Absorption (73°F, 24 hr)	0.80	--	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	1.9	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	508000	334000	psi	ISO 527-2
Tensile Stress (Yield, 73°F)	8700	5800	psi	ISO 527-2
Tensile Strain (Yield, 73°F)	5.2	25	%	ISO 527-2
Tensile Strain (Break, 73°F)	35	75	%	ISO 527-2
Flexural Modulus (73°F)	435000	203000	psi	ISO 178
Flexural Strength (73°F)	13100	6240	psi	ISO 178
Poisson's Ratio	0.40	--		ISO 527-2

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F	2.5	--	ft·lb/in <sup>2</sup>	
73°F	2.6	--	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F	No Break	--		
73°F	No Break	--		
Notched Izod Impact Strength (73°F)	2.4	--	ft·lb/in <sup>2</sup>	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	367	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	149	--	°F	
Melting Temperature (DSC)	482	--	°F	ISO 3146
CLTE - Flow (73 to 131°F, 0.0787 in)	5.6E-5	--	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F, 0.0787 in)	5.6E-5	--	in/in/°F	ISO 11359-2
RTI Elec				UL 746
0.0157 in	149	--	°F	
0.0295 in	266	--	°F	
0.0591 in	266	--	°F	
0.118 in	266	--	°F	
RTI Imp				UL 746
0.0157 in	149	--	°F	
0.0295 in	149	--	°F	
0.0591 in	203	--	°F	
0.118 in	203	--	°F	
RTI Str				UL 746
0.0157 in	149	--	°F	
0.0295 in	203	--	°F	
0.0591 in	203	--	°F	
0.118 in	203	--	°F	

Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity (0.0295 in)	1.0E+10	--	ohm-cm	IEC 60093
Dielectric Strength (0.0394 in)	660	--	V/mil	IEC 60243
Arc Resistance (0.118 in)	PLC 6	--		ASTM D495
Comparative Tracking Index (0.118 in)	400 to 599	--	V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.0295 in	PLC 0	--		
0.0591 in	PLC 0	--		
0.118 in	PLC 0	--		
High Voltage Arc Tracking Rate (HVTR)	PLC 1	--		UL 746
Hot-wire Ignition (HWI)				UL 746
0.0295 in	PLC 0	--		
0.0591 in	PLC 0	--		
0.118 in	PLC 0	--		
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
0.0157 in	V-0	--		
0.0295 in	V-0	--		
0.0591 in	V-0	--		
0.118 in	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.0295 in	1760	--	°F	
0.0591 in	1760	--	°F	
0.118 in	1760	--	°F	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.0295 in	1290	--	°F	
0.0591 in	1290	--	°F	
0.118 in	1340	--	°F	
Oxygen Index	30	--	%	ISO 4589-2

Injection	Dry Unit
Drying Temperature	176 °F
Drying Time	4.0 hr
Suggested Max Regrind	25 %
Rear Temperature	464 to 518 °F
Middle Temperature	464 to 518 °F
Front Temperature	464 to 518 °F
Nozzle Temperature	464 to 518 °F
Processing (Melt) Temp	482 to 518 °F
Mold Temperature	149 to 203 °F

**Notes**

Typical properties: these are not to be construed as specifications.  
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