

Product Texts

Compound designed for parts with maximum mechanical requirements, typically used to replace metal due to the high stiffness and strength, stable after conditioning. It shows better creep behavior and dimensional stability vs. an equivalent PA66 grade, with lower warpage and excellent surface finish.

Flammability @3.2mm nom. HB -
 thickn.
 Flammability @0.4mm nom. HB -
 thickn.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.5 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	21500 / -	MPa	ISO 527
^[C] Stress at break	250 / -	MPa	ISO 527
^[C] Strain at break	2.5 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	85 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	15 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	- / 1700	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Features

Creep Resistance, Low Warpage

Delivery form

Granules, Black

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

Heat stabilized or stable to heat

Other text information

Injection molding

XS compounds, stored in a moisture-proof packaging, can be processed without drying; however, it is always recommended drying the product that comes from a large package (e.g. Octabin). The suggested moisture content for the process of injection molding is less than 0.15% for grades with low percentage of reinforcement; for grades with high percentage of fiber and to achieve the best surface quality, the moisture content should be lower than 0.10% .

Flame retardant grades must be processed with a maximum moisture content of 0,10%.The drying time depends on the initial moisture content and the drying conditions. Typically 4-8 hours at 80-90°C using dehumidified air (dew point of -20°C) are suitable conditions for a starting moisture content of 0.20%-0.40%.

The following conditions apply to a standard injection moulding process of XS compounds. Machine temperatures: barrel 265-290°C, nozzle and hot runners up to 300°C (up to 290°C products with flame retardants). Mould temperatures: 80-100°C, (80-120°C highly reinforced grades). Back pressure: typically 5-10 bar (hydraulic pressure). Temperatures exceeding 300°C and long residence time could lead to degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the moulded part characteristics. For further details, please refer to the document 'Instructions for injection moulding' or contact our technical support team.

Part moulded with XS compounds reach their final performance with a water content of about 1,0% by weight, depending on the grade. This percentage corresponds to the point of equilibrium between the rates of absorption and desorption of moisture. After moulding, in favourable environmental conditions, a part can quickly absorbs moisture up to 0,3-0,5%, while the equilibrium will be reached during its life. Post-treatments of parts may also include the annealing (80-120°C in oven, up to four hours). This procedure can be useful to relax any internal stresses.

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