

**Product Texts**

Injection Molding, 30% Mineral Reinforced, Heat Stabilized, Electrical Conductive, Improved flow

ISO 1043 PA66-(GF+CF)30

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	12000 / 7400	MPa	ISO 527
<sup>[C]</sup> Stress at break	170 / 110	MPa	ISO 527
<sup>[C]</sup> Strain at break	2.5 / 4.5	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	60 / 65	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	60 / 55	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	- / 15	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	- / 10	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Puncture - maximum force, +23°C	840 / -	N	ISO 6603-2
<sup>[C]</sup> Puncture - maximum force, -30°C	700 / -	N	ISO 6603-2
<sup>[C]</sup> Puncture energy, +23°C	3.1 / -	J	ISO 6603-2
<sup>[C]</sup> Puncture energy, -30°C	2.3 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	261 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	240 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	250 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	10 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	100 / *	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Volume resistivity	1000 / -	Ohm*m	IEC 62631-3-1

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	5 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	1.7 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1300 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.07	%	-
Melt temperature	280 - 300	°C	-

Mold temperature

**80 - 120**

°C

-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

Increased electrical conductivity, Heat stabilized or stable to heat

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

**Other text information****Injection molding**

## PREPROCESSING

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

## PROCESSING

Melt temperature (Tmin - Tmax): 280 - 300 °C

Mold temperature: 80 - 120 °C