

**Product Texts**

PA66 flame retardant injection moulding grade, halogen and phosphorus free. 25% glass fibre reinforced. Natural colour.

Suitable for parts requiring fire retardancy along with medium stiffness and good mechanical resistance. Low smoke toxicity and optical density. Rated V-0 according to UL-94.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.4 / *	%	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	14600 / 8800	MPa	ISO 527
<sup>[C]</sup> Stress at break	155 / 95	MPa	ISO 527
<sup>[C]</sup> Strain at break	2.1 / 2.3	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	50 / 60	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	5 / 8	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Yellow Card available	yes / *	-	-
<sup>[C]</sup> Oxygen index	45 / *	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Volume resistivity	1E13 / 1E11	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	* / 1E10	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	2.5 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	1.1 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1740 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 100	°C	-

**Characteristics**
**Processing**

Injection Molding

**Delivery form**

Granules, Natural Color

**Special Characteristics**

Flame retardant, Halogen-free, Phosphorus-free, Heat stabilized or stable to heat

**Additives**

Release agent

**Regional Availability**North America, Europe, Asia Pacific, South and Central America,  
Near East/Africa**Other text information****Injection molding**

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

## Injection Molding Processing Parameters

Melt Temperature

280 - 300°C

Mold Temperature

80 - 100°C

Injection Speed

medium-high