

**Product Texts**

PA66 35% glass fibre reinforced injection moulding grade. Heat stabilized. Deep black colour.

Suitable for parts requiring high stiffness and good mechanical resistance. Excellent heat ageing properties retention, improved welding lines strength. Fit for metal replacement applications.

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	11500 / -	MPa	ISO 527
<sup>[C]</sup> Stress at break	205 / -	MPa	ISO 527
<sup>[C]</sup> Strain at break	3.3 / -	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	100 / -	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

[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> Temp. of deflection under load, 1.80 MPa	235 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	245 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	245 / *	°C	ISO 306
<sup>[C]</sup> Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[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	6.3 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	1.5 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1410 / -	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	≤0.15	%	-
Melt temperature	280 - 310	°C	-
Mold temperature	80 - 100	°C	-

**Characteristics**

**Processing**

Injection Molding

**Special Characteristics**

Heat stabilized or stable to heat

**Delivery form**

Granules, Black

**Regional Availability**

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

**Additives**

Release agent

**Other text information**

**Injection molding**

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. 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 - 310°CMold Temperature  
80 - 100°CInjection Speed  
medium-high