

Product Texts

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

Suitable for parts requiring high stiffness, good mechanical resistance and good heat ageing properties retention.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.1 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	12200 / 8000	MPa	ISO 527
^[C] Stress at break	210 / 140	MPa	ISO 527
^[C] Strain at break	3.1 / 5	%	ISO 527
^[C] Charpy impact strength, +23°C	90 / 100	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	75 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	15 / 20	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	11 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	250 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	255 / *	°C	ISO 75-1/-2
^[C] Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Humidity absorption	1.7 / *	%	Sim. to ISO 62
^[C] Density	1410 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics**Processing**

Injection Molding

Delivery form

Granules, Black

Additives

Release agent

Special Characteristics

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**

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 - 300°C

Mold Temperature

80 - 100°C

Injection Speed

medium-high