

**Product Texts**

Injection Molding, 50% Glass Reinforced, Heat Stabilized

ISO 1043 PA66-GF50

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	0.9 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	16000 / -	MPa	ISO 527
<sup>[C]</sup> Stress at break	230 / -	MPa	ISO 527
<sup>[C]</sup> Strain at break	2.5 / -	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	100 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	100 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	17 / -	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°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	262 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	250 / *	°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> Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	5 / -	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	4.4 / -	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	250 / -	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	230 / -	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	1E13 / -	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Electric strength	38 / -	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	600 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Density	1570 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Material specific properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Viscosity number	146 / *	cm <sup>3</sup> /g	ISO 307, 1157, 1628

[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

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>2 - 6</b>	h	-
Processing humidity	<b>≤0.12</b>	%	-
Melt temperature	<b>280 - 300</b>	°C	-
Mold temperature	<b>80 - 120</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**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**

## PREPROCESSING

Residual moisture content: 0.03 - 0.12%

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