

**Product Texts**

Food Contact Quality, High Viscosity

ISO 1043 PA66

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>3000 / -</b>	MPa	ISO 527
<sup>[C]</sup> Yield stress	<b>80 / -</b>	MPa	ISO 527
<sup>[C]</sup> Yield strain	<b>4 / -</b>	%	ISO 527
<sup>[C]</sup> Nominal strain at break	<b>&gt;50 / -</b>	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	<b>N / -</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	<b>N / -</b>	kJ/m <sup>2</sup>	ISO 179/1eU

[C]: CAMPUS

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	<b>260 / *</b>	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	<b>70 / *</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	<b>215 / *</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	<b>90 / *</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	<b>90 / *</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at thickness h	<b>V-2 / *</b>	class	IEC 60695-11-10
Thickness tested	<b>3.0 / *</b>	mm	-
Yellow Card available	<b>yes / *</b>	-	-

[C]: CAMPUS

<b>Electrical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	<b>3.6 / -</b>	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	<b>3.3 / -</b>	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	<b>90 / -</b>	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	<b>220 / -</b>	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	<b>1E13 / -</b>	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Electric strength	<b>25 / -</b>	kV/mm	IEC 60243-1

[C]: CAMPUS

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<sup>[C]</sup> Water absorption	<b>9 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>2.5 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1140 / -</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

<b>Film Properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> WVTR, 23°C/85%r.h.	<b>24 / *</b>	g/(m <sup>2</sup> *d)	ISO 15106-1/-2
<sup>[C]</sup> Oxygen transmission rate, 23°C/0%r.h.	<b>27 / *</b>	cm <sup>3</sup> /(m <sup>2</sup> *d*bar)	ISO 15105-1/-2
<sup>[C]</sup> Oxygen transmission rate, 23°C/85%r.h.	<b>41 / *</b>	cm <sup>3</sup> /(m <sup>2</sup> *d*bar)	ISO 15105-1/-2
<sup>[C]</sup> Type of extrusion	<b>cast / *</b>	-	-
<sup>[C]</sup> Thickness of specimen	<b>0.06 / *</b>	mm	-

[C]: CAMPUS

<b>Material specific properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Viscosity number	<b>280 / *</b>	cm <sup>3</sup> /g	ISO 307, 1157, 1628

[C]: CAMPUS

**Characteristics****Processing**

Injection Molding, Film Extrusion, Profile Extrusion, Other Extrusion

**Delivery form**

Pellets

**Additives**

Lubricants

**Certifications**

Food contact

**Regional Availability**

Europe

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

## PREPROCESSING

Max. moisture content: 0,2 %

Drying temperature: 90 [°C]

Drying time:

Dehumidifying air dryer: 2 - 20 h (depending on the initial moisture content)

## PROCESSING

Melt temperature: 270 - 290 [°C]

Mould temperature: 80 - 90 [°C]

[Injection Molding Recommendations](#)

[Steel recommendations for molds screws and barrels](#)

[Trouble shooting guideline for injection molding](#)

**Film extrusion**

[Processing of Akulon® Film Grades](#)