

Product Texts

PA66 50% glass fibre reinforced injection moulding grade. Heat stabilized. Black colour.

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

| Processing/Physical Characteristics | dry / cond | Unit | Test Standard |
|--|----------------|------|-----------------|
| ISO Data | | | |
| ^[C] Molding shrinkage, parallel | 0.2 / * | % | ISO 294-4, 2577 |
| ^[C] Molding shrinkage, normal | 0.9 / * | % | ISO 294-4, 2577 |

[C]: CAMPUS

| Mechanical properties | dry / cond | Unit | Test Standard |
|--|----------------------|-------------------|---------------|
| ISO Data | | | |
| ^[C] Tensile Modulus | 16500 / 12000 | MPa | ISO 527 |
| ^[C] Stress at break | 245 / 170 | MPa | ISO 527 |
| ^[C] Strain at break | 2.5 / 3 | % | ISO 527 |
| ^[C] Charpy impact strength, +23°C | 95 / 105 | kJ/m ² | ISO 179/1eU |
| ^[C] Charpy impact strength, -30°C | 90 / - | kJ/m ² | ISO 179/1eU |
| ^[C] Charpy notched impact strength, +23°C | 17 / 22 | kJ/m ² | ISO 179/1eA |
| ^[C] Charpy notched impact strength, -30°C | 15 / - | 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 | 255 / * | °C | ISO 75-1/-2 |
| ^[C] Temp. of deflection under load, 0.45 MPa | 260 / * | °C | ISO 75-1/-2 |
| ^[C] Burning Behav. at thickness h | HB / * | class | IEC 60695-11-10 |
| Thickness tested | 0.4 / * | mm | - |
| Yellow Card available | yes / * | - | - |

[C]: CAMPUS

| Other properties | dry / cond | Unit | Test Standard |
|------------------------------------|-----------------|-------------------|----------------|
| ^[C] Humidity absorption | 1.1 / * | % | Sim. to ISO 62 |
| ^[C] Density | 1580 / - | kg/m ³ | ISO 1183 |

[C]: CAMPUS

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

Mold Temperature

Injection Speed

280 - 300°C

80 - 100°C

medium-high