

Product Texts

PA66 flame retardant injection moulding grade. Halogen and red-phosphorus free. Black colour.

Suitable for parts where fire retardancy is required. Rated V-0 at 0.4 mm according to UL-94. Also suitable for monofilament extrusion.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	1.1 / *	%	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	3400 / 2550	MPa	ISO 527
^[C] Charpy impact strength, +23°C	80 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	55 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	4 / 6	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	3.5 / -	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	70 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	200 / *	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	220 / *	°C	ISO 306
^[C] Burning Behav. at thickness h	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-
Yellow Card available	yes / *	-	-
^[C] Oxygen index	35 / *	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	1E13 / 1E11	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	* / 1E10	Ohm	IEC 62631-3-2
^[C] Comparative tracking index	600 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	7.7 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1170 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding, Other Extrusion

Delivery form

Granules, Black

Additives

Release agent

Special Characteristics

Flame retardant, Halogen-free, Phosphorus-free, Heat stabilized or stable to heat

Applications

Monofilament

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 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. 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
270 - 290°C	60 - 80°C	medium
Extrusion Temperature		
270 - 290°C		