

**Product Texts**

PA66 flame retardant injection moulding grade. Halogen and red phosphorus free. Orange 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.

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	3400 / -	MPa	ISO 527
<sup>[C]</sup> Yield stress	75 / -	MPa	ISO 527
<sup>[C]</sup> Yield strain	4.1 / -	%	ISO 527
<sup>[C]</sup> Nominal strain at break	6 / -	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	50 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	52 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	2.3 / -	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	2.3 / -	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	255 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	70 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Burning Behav. at thickness h	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-
Yellow Card available	yes / *	-	-

[C]: CAMPUS

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

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Density	1190 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Granules

**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

270 - 290°C

Mold Temperature

60 - 80°C

Injection Speed

medium

Extrusion Temperature

270 - 290°C