

Product Texts

PA66 injection moulding grade. Toughened. Natural colour.

Suitable for parts requiring excellent impact resistance, even at low temperatures, and high flexibility.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	1550 / 850	MPa	ISO 527
^[C] Yield stress	42 / 25	MPa	ISO 527
^[C] Yield strain	10 / 30	%	ISO 527
^[C] Charpy notched impact strength, +23°C	105 / 125	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	80 / -	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	65 / *	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	180 / *	°C	ISO 306
^[C] Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[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 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1050 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	60 - 80	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

High impact or impact modified

Delivery form

Granules, Natural Color

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
270 - 290°CMold Temperature
60 - 80°CInjection Speed
medium