

Product Texts

The product is a halogen free flame retardant high temperature polyamide with high flowability, high temperature resistance for surface mount technology (SMT), excellent mechanical properties and high dimension stability, which all make it a perfect fit for E&E applications, especially various thin wall connectors and sockets.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	25 / *	cm ³ /10min	ISO 1133
Temperature	325 / *	°C	-
Load	2.16 / *	kg	-
^[C] Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	12500 / -	MPa	ISO 527
^[C] Stress at break	150 / -	MPa	ISO 527
^[C] Strain at break	2 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	60 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	13 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	305 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	275 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	14 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	62 / *	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Comparative tracking index	- / 600	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1490 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Viscosity number	70 / *	cm ³ /g	ISO 307, 1157, 1628

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	6 - 8	h	-
Processing humidity	≤0.1	%	-
Melt temperature	300 - 330	°C	-
Mold temperature	100 - 140	°C	-

Characteristics

Processing

Injection Molding

Applications

Electrical and Electronical

Delivery form

Pellets, Black

Regional Availability

Asia Pacific

Special Characteristics

Flame retardant, Halogen-free

Other text information**Injection molding**

PREPROCESSING

Pre/Post-processing, max. allowed water content: .1 %

Pre/Post-processing, Pre-drying, Temperature: 120 °C

Pre/Post-processing, Pre-drying, Time: 6 - 8 h

PROCESSING

injection molding, Melt temperature, range: 310 - 340 °C

injection molding, Melt temperature, recommended: 330 °C

injection molding, Mold temperature, range: 100 - 160 °C

injection molding, Mold temperature, recommended: 140 °C

injection molding, Dwell time, thermoplastics: 5 min