

Product Texts

Injection Molding, 30% Mineral Reinforced, Heat Stabilized, Improved Impact, Low Warpage

ISO 1043 PA66-I-MX30

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	1.7 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.6 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	3700 / -	MPa	ISO 527
^[C] Stress at break	60 / -	MPa	ISO 527
^[C] Strain at break	15 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	250 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	200 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	10 / -	kJ/m ²	ISO 179/1eA
^[C] Puncture - maximum force, +23°C	5200 / -	N	ISO 6603-2
^[C] Puncture - maximum force, -30°C	4200 / -	N	ISO 6603-2
^[C] Puncture energy, +23°C	34 / -	J	ISO 6603-2
^[C] Puncture energy, -30°C	17 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	75 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	190 / *	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1330 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Features

Low Warpage

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Other text information

Injection molding

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 4 h

PROCESSING

Melt temperature (Tmin - Tmax): 280 - 300 °C

Mold temperature: 80 - 100 °C