

**Product Texts**

PA66 25% mineral filled injection moulding grade. Improved UV resistance. Black colour.

Suitable for parts requiring good dimensional stability, reduced shrinkage and low warpage. Intended to resist to outdoor exposure.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	66 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	275 / *	°C	-
Load	2.16 / *	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	7100 / 3000	MPa	ISO 527
<sup>[C]</sup> Stress at break	95 / 55	MPa	ISO 527
<sup>[C]</sup> Strain at break	5 / 25	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	70 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	35 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	5 / -	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	260 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> 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
<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

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	6.4 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	1.5 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1340 / -	kg/m <sup>3</sup>	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	280 - 300	°C	-
Mold temperature	80 - 100	°C	-

**Characteristics**

**Processing**

Injection Molding

**Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Delivery form**

Granules, Black

**Features**

Low Warpage

**Additives**

Release agent

**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 0.15%. 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

280 - 300°C

Mold Temperature

80 - 100°C

Injection Speed

medium-high