

Product Texts

PA 66, containing recycled material, 10% mineral filled grade high modulus, for injection moulding applications. Also available heat stabilized (H) and Uv stabilized (UV).

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	30	cm ³ /10min	ISO 1133
Temperature	275	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3400	MPa	ISO 527
Yield stress	75	MPa	ISO 527
Stress at break	70	MPa	ISO 527
Strain at break	10	%	ISO 527
Flexural modulus, 23°C	3600	MPa	ISO 178
Charpy impact strength, +23°C	60	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	6	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	7.5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	90	°C	ISO 75-1/-2
Vicat softening temperature, B	240	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1210	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	250 - 260	°C	-
Zone 2	260 - 270	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	280 - 285	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-
Holding pressure	6 - 8	MPa	-

Characteristics**Processing**

Injection Molding

Certifications

Recycled Resin Content

Delivery form

Black

Regional Availability

Europe

Special Characteristics

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