

Product Texts

PA injection moulding and extrusion grade. Heat stabilized. Natural colour.

Suitable for monofilament extrusion and production of injection moulded technical items. Good properties retention upon long term stay at high temperatures

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	3600 / -	MPa	ISO 527
^[C] Stress at break	88 / -	MPa	ISO 527
^[C] Strain at break	3 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	35 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	3 / -	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	2.5 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	302 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	85 / *	°C	ISO 75-1/-2
^[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 / -	Ohm*m	IEC 62631-3-1

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1170 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing
Injection Molding, Profile Extrusion, Other Extrusion

Special Characteristics
Heat stabilized or stable to heat

Delivery form
Granules, Natural Color

Applications
Monofilament

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 0.10%. Typical conditions with a desiccant drier: temperature 120° C, dew point -20 ° C or below, time 4 h or more. Avoid excessive shear rates and high thermal stresses for better processing. 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	Mold Temperature	Injection Speed
300 - 330°C	90 - 120°C	high

Extrusion Temperature
300 - 320°C