

TECACOMP PA66 GF35 CF10 HI 1014744 - Compounds

Chemical Designation

PA 66 (Polyamide 66)

Main features

→ heat stabilized

Target Industries

→ automotive industry

Colour

black

Density

1.47 g/cm³

Fillers

carbon fibres, glass fibres, heat stabilized

<i>Mechanical properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Tensile strength		244	MPa	DIN EN ISO 527-1	
Modulus of elasticity (tensile test)		17800	MPa	DIN EN ISO 527-1	
Elongation at break (tensile test)		2,3	%	DIN EN ISO 527-1	
Impact strength (Charpy)		70	kJ/m ²	DIN EN ISO 179-1eU	
<i>Thermal properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Glass transition temperature		5 / 72	°C	-	1) (1) moist/dry - literature value
Melting temperature		255	°C	-	2) (2) literature value
Heat distortion temperature		257	°C	ISO-R 75 Method A	3) (3) literature value
Service temperature	short term	170	°C	-	4) (4) literature value
Service temperature	long term	110	°C	-	
<i>Electrical properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
<i>Other properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
<i>Processing parameter</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
processing temperatures		270 - 310	°C	-	
Mould temperature		80 - 110	°C	-	

→ This material can be processed as a thermoplastic taking the normal technical provisions into account. The above mentioned information refers exclusively to the injection moulding process.

→ Processing should be carried out as gently as possible, in order to maintain the maximum fibre length in the component. Back pressure and injection rate should be adjusted to the component geometry accordingly. The optimum processing temperature depends upon the respective geometry of the moulded part and can be different from machine to machine.

<i>Predrying</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Permissible residual moisture content		< 0,1	%	-	
Drying temperature		80 - 120	°C	-	
Drying time		4 - 8	h	-	

→ To achieve optimum mechanical properties, it is recommended to pre-dry the material with the above mentioned parameters.

→ Information on storage and shelf life: The granules must be stored in dry, normally tempered rooms and in closed containers. For moisture-sensitive materials, the granules must be sealed airtight. Protection against direct sunlight must be guaranteed. The granules are usually subject to the requirements of no shelf life limitation. Shelf Life may be limited by some additives.

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