

TECACOMP PA66 GF25 TF10 HI natural 1015068 - Compounds

Chemical Designation

PA 66 (Polyamide 66)

Colour

natural

Density

1.4 g/cm³

Fillers

glass fibres, PTFE, heat stabilized

<i>Mechanical properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Tensile strength	50 mm/min	170	MPa	DIN EN ISO 527-1	
Modulus of elasticity (tensile test)	50 mm/min	8000	MPa	DIN EN ISO 527-1	
Elongation at break (tensile test)	50 mm/min	3,5	%	DIN EN ISO 527-1	
Impact strength (Charpy)	7,5 J	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	DIN 53765	1) (1) moist/dry
Melting temperature		260	°C	DIN 53765	
Service temperature	short term	170	°C	-	
Service temperature	long term	110	°C	-	
<i>Other properties</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Molding shrinkage	longitudinal	0,3	%	DIN EN ISO 294-4	
Molding shrinkage	transverse	1,1	%	DIN EN ISO 294-4	
Bulk density		0,66	g/cm ³	EN ISO 60	
Viscosity number	solution 0,005 g/ml sulphuric acid	150	ml/g	DIN EN ISO 307	
<i>Processing parameter</i>	<i>parameter</i>	<i>value</i>	<i>unit</i>	<i>norm</i>	<i>comment</i>
Cylinder/processing temperature		260 - 310	°C	-	
Mould temperature		90 - 150	°C	-	
Material temperature		290 - 310	°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	°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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