TECACOMP PA66 ID blue 1014971 - Compounds

Chemical Designation
PA 66 (Polyamide 66)

Colour
blue

Density
1.26 g/cm^3

Fillers
detectable filler

former material REZ-RS-4087

Main features
- metal detectable
- x-ray detectable
- Explanation of food contact according to FDA and EU 10/2011 on request

Mechanical properties	*parameter*	*value*	*unit*	*norm*		*comment*
Tensile strength		55	MPa	DIN EN ISO 527-1		
Modulus of elasticity (tensile test)		2400	MPa	DIN EN ISO 527-1		
Elongation at break (tensile test)		24	%	DIN EN ISO 527-1		
Flexural strength		70	MPa	DIN EN ISO 178		
Modulus of elasticity (flexural test)		2000	MPa	DIN EN ISO 178		
Bending strain		6	%	DIN EN ISO 178		
Impact strength (Charpy)		155	kJ/m^2	DIN EN ISO 179-1eU		
Thermal properties	*parameter*	*value*	*unit*	*norm*		*comment*
Glass transition temperature		5 / 72	°C	-	1)	(1) moist / dry
Melting temperature		260	°C	-		
Service temperature	short term	170	°C	-		
Service temperature	long term	110	°C	-		
Other properties	*parameter*	*value*	*unit*	*norm*		*comment*
Detectability	4 x 4 x 4 mm	2,4	mm Al	-	1)	(1) metal detectable (2) x-ray detectable
Molding shrinkage	longitudinal	2,67	%	DIN EN ISO 294-4		
Molding shrinkage	transverse	2,74	%	DIN EN ISO 294-4		
Detectability	4 x 4 x 4 mm	2,4	mm Al	-	2)	
Melt flow index (MFI)	280 °C / 2,16 kg	6,0	g/10 min	DIN EN ISO 1133		
Processing parameter	*parameter*	*value*	*unit*	*norm*		*comment*
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.
- 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.

Predrying	*parameter*	*value*	*unit*	*norm*	*comment*
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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