

TECACOMP PA66 CF10 black 1015049 - Compounds

Chemical Designation

PA 66 (Polyamide 66)

Colour

black

Density

1.17 g/cm³

Fillers

carbon fibres

Mechanical properties	parameter	value	unit	norm	comment
Tensile strength		150	MPa	DIN EN ISO 527-1	
Modulus of elasticity (tensile test)		8000	MPa	DIN EN ISO 527-1	
Elongation at break (tensile test)		3,5	%	DIN EN ISO 527-1	
Impact strength (Charpy)		50	kJ/m ²	DIN EN ISO 179-1eU	
Thermal properties	parameter	value	unit	norm	comment
Glass transition temperature		5 / 72	°C	DIN 53765	1) (1) moist/dry
Melting temperature		260	°C	DIN 53765	
Service temperature	long term	110	°C	-	
Service temperature	short term	170	°C	-	
Other properties	parameter	value	unit	norm	comment
Bulk density		0,53	g/cm ³	EN ISO 604	
Viscosity number	solution 0,005 g/ml sulphuric acid	200	ml/g	DIN EN ISO 307	
Processing parameter	parameter	value	unit	norm	comment
Cylinder/processing temperature		280 - 300	°C	-	
Mould temperature		80 - 120	°C	-	
Material temperature		290 - 300	°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.

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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