

Product description

A glass fibre reinforced, flame retardant, partially aromatic polyamide for injection molding. Good mechanical properties, low water absorption, high melting point (295°C). High tracking resistance, low tendency to form deposits on electrical contacts, very resistant to electrolytic corrosion, resistant to soldering temperatures, can be electroplated.

Physical form and storage

The product is supplied extensively dry in moisture-proof packaging in the form of cylindrical or flat pellets. Its bulk density is about 0,7g/cm³. Standard packs are the special 25kg bag and the 1000kg bulk container (octagonal IBC= intermediate bulk container made from corrugated board with a liner bag). Subject to agreement other forms of packaging and shipment in tankers by road or rail are also possible. All containers are tightly sealed and should be opened only immediately prior to processing. To ensure that the material delivered cannot absorb moisture from the air the containers must be stored in dry rooms and always carefully sealed again after portions of material have been withdrawn. The product can be kept indefinitely in the undamaged bags. Experience has shown that product supplied in IBCs can be stored for about 3 months without any adverse effects on processing properties due to moisture absorption. Containers stored in cold rooms should be allowed to equilibrate to normal temperature so that no condensation forms on the pellets.

Product safety

In case processing is done under conditions as recommended (cf. processing data sheet) melts are thermally stable and do not generate hazards by molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers the product decomposes on exposure to excessive thermal load, e.g. when it is overheated or as a result of cleaning by burning off. Further information is available from the safety data sheet.

Safety instructions

Provide suitable exhaust ventilation at the drying process and in the area surrounding the melt outlet of processing machines.
Closed containers should only be opened in well-ventilated areas.
Ensure thorough ventilation of stores and work areas.

When incorrectly processing an unpleasant odour can be produced, especially when the recommended processing parameters are exceeded.

Check
- Moisture content of pellets
- Melt temperature
- Residence time

When there is a strong odour, immediately check processing parameters, ventilate the area well and recheck moisture content of material. If necessary stop processing and redry the material.

Any short stoppages in production, it is recommended that you inject material into the mould not purge an air shot. Any molten material drooling from the machine nozzle or hot runner nozzles can self-ignite when in open atmosphere. It is therefore advisable to dispose of purgings etc into water containers.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. In order to check the availability of products please contact us or our sales agency.

Product Information

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
Properties			
Polymer abbreviation	-	-	PA6T/6-GF25 FR
Density	ISO 1183	kg/m ³	1380
Viscosity number (0.5% in 96 % H ₂ SO ₄)	ISO 307, 1157, 1628	cm ³ /g	130
Water absorption, saturation in water at 23°C	similar to ISO 62	%	5 - 6
Moisture absorption, equilibrium 23°C/50% r.h.	similar to ISO 62	%	1.10 - 1.50
Processing			
Melting temperature, DSC	ISO 11357-1/-3	°C	295
Melt temperature, injection moulding/extrusion	-	°C	310 - 330
Mould temperature, injection moulding	-	°C	80 - 120
Moulding shrinkage, constrained ³⁾	-	%	0.4
Molding shrinkage (parallel)	ISO 2577, 294-4	%	0.55
Molding shrinkage (normal)	ISO 2577, 294-4	%	1.00
Flammability			
UL 94 rating at 1,6 mm thickness	IEC 60695-11-10	class	V-0
Automotive materials (Thickness >= 1mm) ⁴⁾	FMVSS 302	-	+
Mechanical properties			
			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	8300 / 8000
Stress at break	ISO 527-1/-2	MPa	150 / 140
Strain at break	ISO 527-1/-2	%	3 / -
Tensile creep modulus, 1000 h, strain <= 0.5%, 23°C	ISO 899-1	MPa	* / 6400
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m ²	75 / -
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m ²	13 / -
Izod notched impact strength (23°C)	ISO 180/A	kJ/m ²	13 / -
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	220
Max. service temperature (short cycle operation)	-	°C	270
Temperature index at 50% loss of tensile strength after 5000 h	IEC 216	°C	150
Temperature index at 50% loss of tensile strength after 20000 h	IEC 216	°C	125
Coefficient of linear thermal expansion, longitudinal (23-80)°C	ISO 11359-1/-2	E-6/K	25
Coefficient of linear thermal expansion, transverse (23-80)°C	ISO 11359-1/-2	E-6/K	50 - 60
Thermal conductivity	DIN 52612-1	W/(m K)	0.31
Specific heat capacity	-	J/(kg*K)	1400
Electrical properties			
			dry / cond.
Relative permittivity (1 MHz)	IEC 60250	-	4 / -
Dissipation factor (1 MHz)	IEC 60250	E-4	200 / -
Volume resistivity	IEC 60093	Ohm*m	1E13 / 1E12
Surface resistivity	IEC 60093	Ohm	* / 1E13
Comparative tracking index, CTI, test liquid A	IEC 60112	-	600
Electric strength K20/K20, (60*60*1 mm ³)	IEC 60243-1	kV/mm	37 / 33

Footnotes

1) If product name or properties don't state otherwise.

2) The asterisk symbol "*" signifies inapplicable properties.

3) Test box with central gating, dimensions of base (107*47*1,5) mm, processing condition: TM = 320°C (unreinforced) or 330°C (reinforced), TW = 80°C

4) + = passed

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