

Product description

Glass fibre reinforced injection moulding grade for machinery components and housings of high stiffness and dimensional stability such as coil formers and bearing cages. Also used for electrically insulating parts.

Physical form and storage

The product is supplied dry and ready to use in moisture-proof packaging. The material is in the form of cylindrical or flat pellets. Its bulk density is about 0,7 g/cm³. Standard packs are the special 25 kg bag and the 1000 kg 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 perfectly dry material delivered cannot absorb moisture from the air the containers must be stored in dry rooms and always carefully sealed again after some of the material has been withdrawn. Ultramid® can be stored for a longer period of time in dry, well vented rooms without any change to properties. After longer storage times (> 3 months for IBC or > 2 years for bags) or if material from previously opened containers is used, drying is recommended to remove absorbed moisture. Containers stored in cold rooms should be allowed to equalise 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.

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	-	-	PA66-GF25
Density	ISO 1183	kg/m ³	1320
Viscosity number (0.5% in 96 % H ₂ SO ₄)	ISO 307, 1157, 1628	cm ³ /g	145
Moisture absorption, equilibrium 23°C/50% r.h.	similar to ISO 62	%	1.70 - 2.10
Water absorption, saturation in water at 23°C	similar to ISO 62	%	5.7 - 6.3
Processing			
Melting temperature, DSC	ISO 11357-1/-3	°C	260
MVR 275 °C/5 kg	ISO 1133	cm ³ /10min	40
Melt temperature, injection moulding/extrusion	-	°C	280 - 310
Mould temperature, injection moulding	ISO 294	°C	80 - 90
Moulding shrinkage, constrained ³⁾	-	%	0.55
Molding shrinkage (parallel)	ISO 294-4	%	0.48
Molding shrinkage (normal)	ISO 294-4	%	1.06
injection molding, Melt temperature, recommended	-	°C	290
injection molding, Mold temperature, recommended	-	°C	80
Flammability			
UL 94 rating at 1,6 mm thickness	IEC 60695-11-10	class	HB
Automotive materials (Thickness >= 1mm) ⁴⁾	ISO 3795, FMVSS 302	-	+
Mechanical properties			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	8600 / 6000
Stress at break	ISO 527-1/-2	MPa	170 / 115
Strain at break	ISO 527-1/-2	%	3 / 6
Tensile creep modulus, 1000 h, strain <= 0.5%, 23°C	ISO 899-1	MPa	* / 4300
Flexural modulus	ISO 178	MPa	7600 / 6000
Flexural strength	ISO 178	MPa	260 / 200
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m ²	68 / 96
Charpy unnotched impact strength (-30°C)	ISO 179/1eU	kJ/m ²	60 / -
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m ²	8.7 / 10.8
Charpy notched impact strength (-30°C)	ISO 179/1eA	kJ/m ²	8 / -
Izod notched impact strength (23°C)	ISO 180/A	kJ/m ²	9.5 / 15
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	245
HDT B (0.45 MPa)	ISO 75-1/-2	°C	260
Max. service temperature (short cycle operation) ⁵⁾	-	°C	240
Temperature index at 50% loss of tensile strength after 5000 h	IEC 60216	°C	170
Temperature index at 50% loss of tensile strength after 20000 h	IEC 60216	°C	140
Coefficient of linear thermal expansion, longitudinal (23-55)°C	ISO 11359-1/-2	E-6/K	28
Coefficient of linear thermal expansion, transverse (23-55)°C	ISO 11359-1/-2	E-6/K	97
Thermal conductivity	DIN 52612-1	W/(m K)	0.34
Specific heat capacity	-	J/(kg*K)	1600
Electrical properties			dry / cond.
Relative permittivity (1 MHz)	IEC 62631-2-1	-	3.5 / 5.5
Dissipation factor (1 MHz)	IEC 62631-2-1	E-4	140 / 1600
Volume resistivity	IEC 62631-3-1	Ohm*m	1E13 / 1E10
Surface resistivity	IEC 62631-3-2	Ohm	* / 1E10
Comparative tracking index, CTI, test liquid A	IEC 60112	-	- / 550
Electric strength K20/P50, d = 0.6 - 0.8 mm	IEC 60243-1	kV/mm	90 / 80
Electric strength K20/K20, (60*60*1 mm ³)	IEC 60243-1	kV/mm	47 / 39

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 conditions: TM = 290°C, TW = 80°C

4) + = passed

5) Empirical values determined on articles repeatedly subjected to the temperature concerned for several hours at a time over a period of several years. Provisio Proper design and processing according to our recommendations.

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