

Product description

Glass fibre reinforced injection moulding grade with optimised heat ageing performance for industrial articles having very high rigidity.

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air the containers must be stored in dry rooms and always carefully sealed again after some of the material has been withdrawn.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-GF50
Density	ISO 1183	kg/m ³	1580
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	%	1.00 - 1.40
Water absorption, saturation in water at 23°C	similar to ISO 62	%	3.7 - 4.3
Processing			
Melting temperature, DSC	ISO 11357-1/-3	°C	260
MVR 275 °C/5 kg	ISO 1133	cm ³ /10min	10
Melt temperature, injection moulding/extrusion	-	°C	280 - 310
Mould temperature, injection moulding	ISO 294	°C	80 - 90
Moulding shrinkage, constrained ³⁾	-	%	0.4
Molding shrinkage (parallel)	ISO 294-4	%	0.40
Molding shrinkage (normal)	ISO 294-4	%	0.90
injection molding, Melt temperature, recommended	-	°C	300
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	16500 / 12000
Stress at break	ISO 527-1/-2	MPa	250 / 175
Strain at break	ISO 527-1/-2	%	2.7 / 4.1
Flexural modulus	ISO 178	MPa	15600 / 11600
Flexural strength	ISO 178	MPa	390 / 280
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m ²	105 / 105
Charpy unnotched impact strength (-30°C)	ISO 179/1eU	kJ/m ²	100 / 100
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m ²	16 / 19
Charpy notched impact strength (-30°C)	ISO 179/1eA	kJ/m ²	14 / 14
Izod notched impact strength (23°C)	ISO 180/A	kJ/m ²	18 / 21
Izod notched impact strength (-30°C)	ISO 180/A	kJ/m ²	16 / 16
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	250
HDT B (0.45 MPa)	ISO 75-1/-2	°C	250
Max. service temperature (short cycle operation) ⁵⁾	-	°C	240

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. Provision Proper design and processing according to our recommendations.

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