

Description

Flame retardant polyamide PA 66, unreinforced, for injection moulding.

Product Applications

This phosphorous flame retardant grade , UL 94 V0 (0.8 mm) , is suitable for moulding insulating parts for electrical components:

- terminal blocks
- connectors

This product is available in natural and black.

Processing

The material is supplied in airtight bags, ready for use. In the case that the virgin material has absorbed moisture, it must be dried to a final moisture content of less than 0,2% with a dehumidified air drying equipment at approx 80°C.

Recommended moulding conditions:

Barrel temperatures :

- feed zone 270 - 275°C
- compression zone 275 - 280°C
- front zone 280 - 285°C

Mould temperatures : 60 at 80°C

For more detailed information , please refer to the technical sheet Injection moulding.

Safety

Please refer to the Safety Data Sheet BULMEN1R8FS.

TECHNYL® A 20

The values of properties are for natural grade.

Properties	Standards	Unit	Values	
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Physical				
Water absorption (24 h at 23°C)	ISO 62	%	1.15	-
Density	ISO 1183-A	g/cm3	1.17	-
Molding shrinkage Parallel (1) (RHODIA-EP)	RHODIA-EP	%	1.90	-
Molding shrinkage normal or perpendicular (1) (Rhodia EP)	RHODIA-EP	%	1.90	-
Mechanical				
Tensile modulus	ISO 527 type 1 A	MPa	3300	2000
Tensile strength at yield	ISO 527 type 1 A	MPa	85	45
Elongation at yield	ISO 527 type 1 A	%	6	7
Elongation at break	ISO 527 type 1 A	%	6	50
Tensile strength at break	ISO 527 type 1 A	MPa	85	40
Flexural modulus	ISO 178	MPa	3200	1700
Flexural maximum stress	ISO 178	MPa	125	60
Charpy notched impact strength	ISO 179/1eA	kJ/m2	2.5	2.70
Charpy unnotched impact strength	ISO 179/1eU	kJ/m2	50	-
Charpy unnotched impact strength	ISO 179/1eU	kJ/m2	-	NB
Izod notched impact strength	ISO 180/1A	kJ/m2	3.5	4.5
Flamability				
Flammability UL 94 (Thickness 0,8 mm)	ISO 1210/UL 94		V0	-
Flammability UL 94 (Thickness 1,6 mm)	ISO 1210/UL 94		V0	-
Flammability UL 94 (Thickness 3,2 mm)	ISO 1210/UL 94		V0	-
Glow wire flammability index (thickness = 1,6)	IEC 60695-2-12	°C	960	-
Limit Oxygen index	ISO 4589		31.5	-
Thermal				
Melting Temperature	ISO 11357	°C	263	-
Electrical				
Dissipation factor	IEC 60250		0.02	0.05
Volume resistivity	IEC 60093	Ohm.cm	10E14	10E13
Surface resistivity	IEC 60093	Ohm	50E13	40E12
Dielectric strength	IEC 60243	kV/mm	35	35
Comparative tracking index sol. A	IEC 60112	Volt	500	475
Comparative tracking index sol. B	IEC 60112	Volt	500	-

Identification Code : >PA66 FR(52)<

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