NOVAMIDE PA66 FR Y FV25 PH

novalca

PA66 compound,
Glass fiber reinforced,
Flame retardant grade

FR: flame retardant, V0 at 1.6 mm
FV25: 25% glass fiber reinforced
Y: UL94 V0 0.8 mm homologated, colors BK and NC, ASTM CTI PLC 1, UL file number E168806
PH: flame retardant system based on red phosphorous
Color: available in black and in natural (brick red).

RECOMMENDED PROCESSING PARAMETERS FOR INJECTION MOLDING		
DRYING CONDITIONS (dehumidifying or desiccant dryer)	**BARREL TEMPERATURE**	**MOULD TEMPERATURE**
Drying time is depending on moisture content, in general 2 ÷ 6 h at 80°C is sufficient. Recommended moisture levels after drying: 0.03 ÷ 0.06%	**260 ÷ 290 °C** **Don't overheat, avoid long residence time in the barrel, avoid over dimensioned machines, hot runners molds not recommended. Provide suitable exhaust ventilation at the drying and in the processing areas. Ensure thorough ventilation of stores and work areas.**	**70 ÷ 100 °C**

SHRINKAGE: Shrinkage is affected by the geometry and the wall thickness of the molded part by the position and size of the gate and by the processing parameters (melt and mold temperature, holding pressure and holding pressure time together with the storage time and storage temperature). The interaction of these various factors makes it difficult to predict the shrinkage of a part exactly.
In addition, glass-fiber reinforced products show a significant difference in the shrinkage perpendicular and parallel to the flow direction. It must be considered the post-shrinkage component too, giving reise to a dimensional change over the time.

PACKAGING

25 Kg Bags, 1000 Kg Octabins, 750 Kg Boxes

PROPERTIES	METHOD		CONDITION	UNIT	VALUES
PHYSICAL					
Density	ASTM D792	ISO 1183	Dry	gr/cm^3	**1.35**
Humidity Absorption (equilibrium value, in air, +23°C, 50% RH)	INTERNAL METHOD		-	%	**1.4 ÷ 1.7**
Reinforcing filler	INTERNAL METHOD		-	%	**25**
MECHANICAL					
Tensile strength: stress at break	ASTM D638	ISO 527-1,-2	Dry	MPa	**110**
strain at break	ASTM D638	ISO 527-1,-2	Dry	%	**2.6**
Flexural modulus	ASTM D790	ISO 178	Dry	MPa	**6500**
IZOD notched impact strength, at 23 °C Specimen dimensions 62.5 mm x 12.7 mm x 3.2 mm	ASTM D256	-	Dry	J/m	**60**
THERMAL					
Melting point DSC, component PA66	ISO 11357		Dry	°C	**PA66** **255 ÷ 265**
ELECTRICAL					
Comparative tracking index (solution A, CTI)	VDE 0303-P1	IEC 60112	Dry	V	**≥ 500**
Comparative tracking index (solution A, CTI)	ASTM D3638	-	-	PLC	**1**
FLAMMABILITY					
Flammability UL 94 (thickness 3.2 mm)	UL 94		Dry	Class	**V0**
Flammability UL 94 (thickness 1.6 mm)	UL 94		Dry	Class	**V0**
Glow wire flammability GWFI (thickness 3.2 mm)	IEC 60695-2-12		-	°C	**960**
Glow wire flammability GWFI (thickness 2 mm)	IEC 60695-2-12		-	°C	**960**
Burning rate FMVSS302 (thickness 2.2/ 3.2 mm)	ISO 3795		Dry	mm/min	**passed**

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