



NOVAMIDE PA66 FR Y FV25 PH

PA66 compound, FR: flame retardant, V0 at 1.6 mm
Glass fiber reinforced, FV25: 25% glass fiber reinforced
Flame retardant grade 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 \div 6 h at 80°C is sufficient. Recommended moisture levels after drying: 0.03 \div 0.06%	260 \div 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 \div 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 rise 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 \div 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 \div 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

Our technical data are provided for guidance purpose only and are based on average values. The data are not meant to be used for specification or warranted purposes. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the data have been established on standardized test specimens at room temperature. All technical information is subject to continuous update, so the customer shall always ensure that the latest release of technical information is at his own disposal. It is the customer's responsibility to inspect and test our products in order to determine to his own satisfaction whether they are suitable for his intended uses and applications or used in conjunction with third-party materials. This material is not suitable for applications in the pharmaceutical, medical, dental and toys sectors, in contact with foodstuff or for potable water transportation.

Updating: January 2025 Printing date: 19 December 2025

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