

Polyamide 6.6 black lubricated 20% carbon fibre reinforcement, heat stabilized for injection moulding.

TECHNICAL DATA SHEET

| | | STANDARD | UNIT | DRY | CONDITIONED |
|----------|-----------------|----------|--------------------|----------|-------------|
| GENERALS | Density | ISO 1183 | gr/cm ³ | 1,23 | |
| | Melt Flow Index | ISO 1133 | gr/10 min. | - | |
| | Humidity Pelets | ISO 1110 | % | 0,2 | |
| | Hardness | SHORE D | Points | 83 | |
| | Mold Shrinkage | - | % | ~0,4-0,6 | |

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|----------------|---------------------|----------------|-------------------|-------------------|-------------|--|
| MECHANICAL | Tensile Strenth | ISO 527 | N/mm ² | 190 | | |
| | Elogantion at break | ISO 527 | % | 3 | | |
| | Tensile Modulus | ISO 527 | N/mm ² | 15000 | | |
| | Charpy Impact | 23 °C ISO 179 | | Kj/m ² | 65 | |
| | | -40 °C ISO 179 | | Kj/m ² | - | |
| | Charpy Impact | 23 °C ISO 179 | | Kj/m ² | 10 | |
| -40 °C ISO 179 | | | Kj/m ² | - | | |

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| ELECTRICAL | Surface Resistivity | IEC 93 | Ohm | 10 ¹³ | |
| | Dielectric strength | IEC 243 | Kv/mm | - | |
| | Tracking index (C.T.I.) | IEC 112 | Kv/mm | - | |

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| THERMAL | Deflection Temp. Under Load | 0,4 N ISO 75/A | °C | 255 | |
| | | (H.D.T.) | 1,8 N ISO 75/A | °C | 250 |
| | VICAT Temperatura | ISO 306 | °C | - | |
| | | | | | |

- The values provided in this data sheet correspond to our knowledge. All products must be subjected to in company test by the user before application.
- These datas do not release you from the obligation to test our products as to their suitability for the intended processes and final use.
- These data may not valid such material used in combination with any other materials or additives or in - any process.
- Triesa assumes no liability and makes no warranties of any kind, expressed or implied how to use this information data.
- UL measurements are done in our lab according to this norm.

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| OTHERS | UL - Flammability | UL-94 | - | HB |
| | Glow Wire | IEC 695 | °C | - |
| | Fammability speed | FMV 302 | mm/min. | <100 |
| | Ashes | Triesa Test | % | ~20 |
| | Water absorption (24h) | ISO 62 | % | - |
| | Heat Stabilized | | | YES |

RECOMMENDED VALUES

| | | |
|------------|------------------------|---------------|
| PROCESSING | Drying Material | 3h - 4h 100°C |
| | Mold. Temperature | 70°C-100°C |
| | Processing Temperature | 275°C-290°C |
| | Back Temperature | 265°C-275°C |
| | Middle Temperature | 275°C-285°C |
| | Nozzle Temperature | 285°C-290°C |
| | Hold Pressure | 80 - 110 Mpa |

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SOURCE: Triesa Quality Control; Last update: 12/05/2020