

ISSUED: 25/11/2020

ISO 9001 CERTIFIED

Promyde A30 P2 G35 U0 P BL04N is an injection moulding grade of Polyamide 66 with 35% glass fibre, and flame retardant using a **halogen free** flame retardant system. Black colour.

PROPERTIES	CONDITIONS	TEST METHOD	UNITS	VALUES
<b>PHYSICAL PROPERTIES</b>				
Density	23 °C	ISO 1183	g/cm <sup>3</sup>	1,46
<b>FLAMMABILITY</b>				
Flammability	0,8 mm	UL-94	Class	V-0
Flammability	1,5 mm	UL-94	Class	V-0
Glow Wire Flammability Index	1,5 mm	IEC 60695-2-12,13	°C	960
<b>PROCESSING CONDITIONS</b>				
Melt temperature, injection moulding			°C	270 - 300
Mould temperature			°C	70 - 100
Moulding Shrinkage	longitudinal transversal		%	0,3 - 0,6 0,7 - 1,0
<b>MECHANICAL PROPERTIES</b>				<b>DAM *</b>
Tensile modulus	23 °C, 1 mm/min	ISO 527-1/-2	MPa	11.000
Tensile strength	23 °C, 5 mm/min	ISO 527-1/-2	MPa	180
Elongation at break	23 °C, 5 mm/min	ISO 527-1/-2	%	2,90
Flexural modulus	23°C, 2 mm/min	ISO 178	MPa	9.500
Flexural strength	23°C, 2 mm/min	ISO 178	MPa	265
Charpy unnotched impact strength	23°C	ISO 179/1eU	kJ/m <sup>2</sup>	75
Charpy notched impact strength	23°C	ISO 179/1eA	kJ/m <sup>2</sup>	14,2
<b>THERMAL PROPERTIES</b>				
Melting temperature (DSC)	10°C/min	ISO 3146	°C	260
Heat Deflection Temperature (HDT)	1,8 MPa	ISO 75-2	°C	220
<b>ELECTRICAL PROPERTIES</b>				<b>(dry/cond.)*</b>
Surface resistivity		IEC 60093	Ω	10 <sup>12</sup> / 10 <sup>10</sup>
Comparative tracking index		IEC 60112	V	450

\* DAM = dry as moulded

## CHARACTERISTICS

Promyde A30 P2 G35 U0 P BL04N is a Polyamide 66 with 35% glass fibre with extra high mechanical strength, heat stabilized and lubricated for **injection moulding**. Its **halogens free flame retardant system** enhances its flame behavior to V0-UL94 rated category. Black colour.

## APPLICATIONS

Promyde A30 P2 G35 U0 P BL04N allows a **fast and efficient mould filling**, and an **easy mould release**, that combined with its **excellent mechanical properties**, and its flame-retardant properties make it suitable for components specially used in electrical and electronics industries.

## FORMAT AND STORAGE

Promyde A30 P2 G35 U0 P BL04N is supplied in moisture-proof packaging. Typical formats are Big Bag, octabin, and 25kg bags.

All containers are perfectly sealed. The product should be stored in a dry place and opened just before processing.

## PROCESSING GUIDELINES

### Drying

Material is supplied ready to process with low moisture content and barrier packaging.

However, drying is typically recommended. Max. Water content should be: 0.05%.

Drying conditions are:

Drying temperature  $\leq 90$  °C

Drying time: 3-6 hours

### Injection moulding

The recommended processing parameters for injection moulding are:

Melt temperature: 270-300°C

Mould temperature: 70-100 °C

Injection speed: medium to high

Back pressure: moderate

Hot runner moulds are not recommended, but they may be used when a very tight temperature control is assured, overall in the gate(s), and the cycle time is short.

### Shrinkage

The shrinkage of a moulded part is influenced by wall thickness, mould gating, and moulding conditions.

### Moisture

A particular characteristic of reinforced polyamide 66 is its combination of moderate tensile and flexural strength with rigidity, good impact strength, and friction resistance. However, when a moulded part absorbs moisture, tensile and flexural strength decrease and toughness increases.

## NOTE

All recommendations are based on knowledge and experience; The values have been established on standardized tests. The figures should be regarded as guide values and not as binding minimum values. As many factors may affect processing or applications, we recommend that customers make their own tests to determine the suitability of a product for its particular use.