

ISSUED: 25/11/2020

ISO 9001 CERTIFIED

Promyde ® B30 P2 M25 U2 is a Polyamide 6 injection moulding grade halogen free flame retardant with 25% mineral filler and heat stabilized. This product is available in all colours upon request.

PROPERTIES	CONDITIONS	TEST METHOD	UNITS	VALUES
PHYSICAL PROPERTIES				
Density	23 °C	ISO 1183	g/cm ³	1,37
Moisture absorption	23 °C / 50% r.h.	ISO 62	%	2,2
Water absorption	23 °C / saturation in water	ISO 62	%	7,0
Flammability	1,5 mm	UL-94		V-2
Glow wire flammability index	1,5 mm	IEC 60695-2-12,13	°C	960
Glow wire ignitability temperature	1,5 mm	IEC 60695-2-12,13	°C	725
PROCESSING CONDITIONS				
Melt temperature, injection moulding			°C	250-270
Mould temperature			°C	40-80
MECHANICAL PROPERTIES (dry/cond.)*				
Tensile modulus	23 °C, 1 mm/min	ISO 527-1-2	MPa	6.000 / -
Tensile strength	23 °C, 50 mm/min	ISO 527-1-2	MPa	75 / -
Elongation at break	23 °C, 50 mm/min	ISO 527-1-2	%	3,0 / -
Flexural modulus	23 °C, 2 mm/min	ISO 178	MPa	5.200 / -
Flexural strength	23 °C, 2 mm/min	ISO 178	MPa	120 / -
Charpy unnotched impact strength	23°C	ISO 179/1eU	kJ/m ²	35 / -
Charpy notched impact strength	23°C	ISO 179/1eA	kJ/m ²	3,5 / -
THERMAL PROPERTIES				
Melting temperature (DSC)	10°C/min	ISO 3146	°C	222
Heat Deflection Temperature (HDT)	1,8 MPa	ISO 75-1-2	°C	150
Thermal coefficient of linear expansion	23-80°C long. 23-80°C transv.	ISO 11359-1/-2	10 ⁻⁴ /K	0,2 0,6
ELECTRICAL PROPERTIES (dry/cond.)*				
Dielectric constant	1MHz	IEC 60250		3,7 / 6,8
Dissipation factor	1 MHz	IEC 60250		230 / 2.200
Volume resistivity		IEC 60093	Ω.m	10 ¹³ / 10 ¹⁰
Surface resistivity		IEC 60093	Ω	10 ¹³ / 10 ¹⁰
Comparative tracking index		IEC 60112		525

* dry = dry as moulded / cond.= conditioned according to ISO 1110

CHARACTERISTICS

Promyde ® B30 P2 M25 U2 is distinguished by high resistance to mechanical stresses and impacts. Parts made from Promyde ® B30 P2 M25 U2 have resistance to Glow Wire test 960°C and a good injection processability in thin wall parts.

APPLICATIONS

Promyde ® B30 P2 M25 U2 is used in a wide range of applications where a combination of mechanical properties and glow wire resistance is needed.

Mineral reinforced grades are suitable for housings, supports, industrial articles and electrical components support.

FORMAT AND STORAGE

Promyde ® B30 P2 M25 U2 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. When moisture absorption is prevented drying is not required. When drying is necessary, conditions are:

Drying temperature ≤ 80 °C

Drying time: 4-6 hours

Injection moulding

The recommended processing parameters for injection moulding are:

Melt temperature: 250-270°C

Mould temperature: 40-80 °C

Injection speed: medium to high

Back pressure: moderate

Shrinkage

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

Moisture

A particular characteristic of reinforced polyamide 6 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.