

PRODUCT CODE : DM357
PRODUCT DESCRIPTION : PA66, 15% MINERAL FILLER, NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1,19-1,21
	MOLDING SHRINKAGE	PARALLEL	ISO 294-4	%	1-2
	MOISTURE CONTENT	-	ISO 15512	%	<0.2
	ASH CONTENT	750 °C±50 °C	ISO 3451	%	15-20

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	70-80
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	-
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	3-5
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	3000-4000
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	3-5
	IZOD IMPACT STRENGTH, NOTCHED	-30°C	ISO 180/A	kJ/m ²	-

THERMAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	VICAT SOFTENING TEMPERATURE	50 N	ISO 306	°C	-
	HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75	°C	-
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	-
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	260

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ELECTRICAL&FLAMMABILITY	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	-
	FLAME RATING	1,6 mm	UL 94	-	-
	GLOW WIRE FLAMMABILITY INDEX	2 mm	IEC 60695	°C	-
	GLOW WIRE IGNITABILITY TEMPERATURE	2 mm	IEC 60695	°C	-
	COMPARATIVE TRACKING INDEX	Solution A	ISO 60112	Volt	-
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	-
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	-

INJECTION PROCESS	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	100-120
	PREDRYING TIME	hours	3-4
	MELTING TEMPERATURE	°C	260-290
	NOZZLE TEMPERATURE	°C	250-270
	PRE- 3 REGION TEMPERATURE	°C	260-280
	MID-2 REGION TEMPERATURE	°C	260-280
	AFT-1 REGION TEMPERATURE	°C	260-280
	MOLD TEMPERATURE	°C	80-100

Data are based on dry conditions

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