

### ECONAMID® FL 66G25H1

Polyamide 66, 25% glass fiber reinforced, heat stabilized, for injection moulding

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
<b>PRODUCT IDENTIFICATION</b>				
ISO 1043 abbreviation		ISO 1043		PA66-GF25
<b>PHYSICAL</b>				
Density		ISO 1183	[g/cm <sup>3</sup> ]	1,32
<b>MECHANICAL</b>				
Tensile modulus	1 mm/min	ISO 527	[MPa]	8000
Tensile stress at break	5 mm/min	ISO 527	[MPa]	135
Tensile strain at break	5 mm/min	ISO 527	[%]	3
Flexural modulus	2 mm/min	ISO 178	[MPa]	6900
Flexural strength	2 mm/min	ISO 178	[MPa]	170
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m <sup>2</sup> ]	35
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m <sup>2</sup> ]	5
Izod impact unnotched	+23 °C	ISO 180/1U	[kJ/m <sup>2</sup> ]	30
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m <sup>2</sup> ]	5
<b>THERMAL</b>				
Melting point	DSC	ISO 11357-1	[°C]	262
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	255
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	250
<b>ELECTRICAL</b>				
Volume resistivity		IEC 62631-3-1	[Ω·cm]	10 <sup>15</sup>
Surface resistivity		IEC 62631-3-2	[Ω]	10 <sup>13</sup>
<b>BURNING BEHAVIOUR</b>				
Flammability	0,8 mm	UL 94	[Class]	HB
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products

#### PROCESSING CONDITIONS:

Drying temperature/time	: 75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	: 260-285 °C
Recommended mould temperature	: 80-120 °C

*These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. ECONAMID grades are not recommended for injection moulding hot runner systems with a diameter below 1mm*

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