

Technical Data Sheet



ALCOM LB PA66 FC 1000 17204 BL1210-17

Base Polymer	Polyamide 66
Special Features	injection moulding grade,easy release (demoulding),heat stabilised,food contact
Market Segment	food processing industry,various
Application Area	injection moulded parts,light blocking components

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h max. moisture content <0,15 %
Processing Injection Moulding	melt temperature 260-290 °C mould temperature 80-100 °C
Storage	dry, protected from light
Minimum Shelf Life	months <12

Properties	dry/cond.	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	3100 / 1500	MPa	ISO 178
Flexural Stress (3.5% Strain)	95 / 40	MPa	ISO 178
Tensile Modulus	3400 / 1600	MPa	ISO 527
Tensile Stress at Yield	- / 60	MPa	ISO 527
Tensile Strength	90 / -	MPa	ISO 527
Tensile Elongation at Yield	- / 20	%	ISO 527
Tensile Elongation at Break	14 / 100	%	ISO 527
Impact Strength (Charpy, 23°C)	200 / 1000	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	100 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	4.5 / 13	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	3 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	83 / *	°C	ISO 75-1/-2
DSC (Melt Point)	263 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	1.2 - 1.6	%	ISO 294-4
Shrinkage (lateral, 24h)	0.8 - 1.2	%	ISO 294-4
Physical Properties			
Density	1160 / -	kg/m ³	ISO 1183
Optical Properties			
Tristimulus Value Y10 of Reflection (d=2,0mm)	25	%	DIN 5033
Tristimulus Value Y10 of Transm.,d=0.5mm		%	ISO 13468