

Technical Data Sheet



ALTECH PA66 A 1000/109 BK1008-13LS

Base Polymer	Polyamide 66
Filler/Additive System	laser optimisation,Laser sensitive additive
Colour	black
Special Features	heat stabilised,easy release (demoulding),easy flow,laser etchable (light etching)
Market Segment	Automotive,electrical and electronic
Application Area	injection moulded parts,interior decoration / finishing,electrical and electronic (E&E),electrical components
Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h dependant on moisture content max. moisture content <0,15 %
Processing Injection Moulding	melt temperature 270-290 °C mould temperature 60-100 °C
Storage	dry, protected from light

Properties	dry/cond.	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	3300 / -	MPa	ISO 178
Flexural Stress (3.5% Strain)	100 / -	MPa	ISO 178
Tensile Modulus	3300 / -	MPa	ISO 527
Tensile Strength	80 / -	MPa	ISO 527
Tensile Elongation at Break	3.5 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	30 / -	kJ/m²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	25 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	3 / -	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	2 / -	kJ/m²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	80 / *	°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)	1.8 - 2.2	%	ISO 294-4
Physical Properties			
Density	1130 / -	kg/m³	ISO 1183
Flammability			
Flammability (0.75 mm)	HB / *	class	UL 94
Yellow Card available	yes / *	-	-