

## Technical Data Sheet



### ALTECH PA66 A 1000/510 IM

|                  |                                                                        |
|------------------|------------------------------------------------------------------------|
| Base Polymer     | Polyamide 66                                                           |
| Colour           | black                                                                  |
| Special Features | impact modified,heat stabilised                                        |
| Market Segment   | Automotive                                                             |
| Application Area | injection moulded parts,interior decoration / finishing,exterior parts |

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   |
|----------------------------------------|--------------|------------------------|-------------|
| <b>Mechanical Properties</b>           |              |                        |             |
| Flexural Modulus                       | 2300 / -     | MPa                    | ISO 178     |
| Flexural Stress (3.5% Strain)          | 74 / -       | MPa                    | ISO 178     |
| Tensile Modulus                        | 2500 / -     | MPa                    | ISO 527     |
| Tensile Stress at Yield                | 60 / -       | MPa                    | ISO 527     |
| Tensile Elongation at Yield            | 4.6 / -      | %                      | ISO 527     |
| Tensile Elongation at Break            | 20 / -       | %                      | ISO 527     |
| Impact Strength (Charpy, 23°C)         | no break / - | kJ/m <sup>2</sup>      | ISO 179/1eU |
| Notched Impact Strength (Charpy, 23°C) | 16 / -       | kJ/m <sup>2</sup>      | ISO 179/1eA |
| <b>Thermal Properties</b>              |              |                        |             |
| HDT / A (1,8 MPa)                      | 66 / *       | °C                     | ISO 75-1/-2 |
| DSC (Melt Point)                       | 265 / *      | °C                     | ISO 11357   |
| <b>Rheological Properties</b>          |              |                        |             |
| Melt Index (MVR)                       | 50 / *       | cm <sup>3</sup> /10min | ISO 1133    |
| MVR temperature                        | 275 / *      | °C                     | -           |
| MVR load                               | 5 / *        | kg                     | -           |
| Shrinkage (lengthwise, 24h)            | 1.2 - 1.6    | %                      | ISO 294-4   |
| Shrinkage (lateral, 24h)               | 1.5 - 1.9    | %                      | ISO 294-4   |
| <b>Physical Properties</b>             |              |                        |             |
| Density                                | 1100 / -     | kg/m <sup>3</sup>      | ISO 1183    |