

# HERAMID A GRI 7645 ECP1904

## DESCRIPTION

PA66 15% mineral filled injection moulding grade. Heat stabilized. Toughened. Grey colour.

Post-industrial grade produced with selected polymers coming from polymerization, fibres and compounding plants.

ISO 1043 : PA66-I MX15

## MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more.

Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

### Processing Parameters

Melt Temperature:	Mold Temperature:	Injection Speed:
280 ÷ 300 °C	80 ÷ 100 °C	Medium-high

## PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2002/95/CE and following amendments

## Technical data sheet

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PROPERTY	STANDARD	UNIT	VALUE	
			DAM*	Cond**
<b>Physical Properties</b>				
Density	ISO 1183	Kg/m <sup>3</sup>	1210	
<b>Mechanical Properties</b>				
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	3500
Stress at Break	5mm/min	ISO 527-2/1A	MPa	70
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	10
Flexural Modulus	2mm/min	ISO 178	MPa	3200
Flexural Strength	2mm/min	ISO 178	MPa	110
Charpy Impact Strength	+23°C	ISO 179/1 eU	KJ/m <sup>2</sup>	80
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	KJ/m <sup>2</sup>	8
<b>Thermal Properties</b>				
Melting Temperature	10°C/min	ISO 11357-1-3	°C	265
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	80
Vicat Softening Temperature	50°C/h	ISO 306/B50 50N	°C	90
<b>Flammability Properties</b>				
Flammability	0.8mm	UL 94	class	HB

\*DAM = Dry As Moulded state \*\*Cond = Conditioned state similar to ISO 1110 \*\*\*Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]