ESTER INDUSTRIES LTD.

Product Data Sheet
ESTOPLAST XU6250GY01
[PA66-GF] Compound

Product Description

Polyamide 66 - Glass Fiber Reinforced, 50%

Product Applications

Automotive: Intake manifold, Engine, Powertrain, Interior trim, Electrical components and connectors

Electrical & Electronic: Low voltage switch gear/power distribution, Lighting, Power connectors, MCCB,

General

Material Status	• Commercial : Active
Filler/Reinforcement	• Glass - Fiber reinforcement , 50%
Forms	• Pellets
Additive	• Mold Release
RoHS Compliance	• ROHS compliant
Appearance/Color	• Natural
Processing Method	• Injection molding

Physical	Typical Value	Unit	Test Method
Specific Gravity	1.58	-	ASTM D - 792
Water Absorption			
Saturation, 23°C	1.5	%	ISO 62
Equilibrium, 23°C, 50%RH	0.7	%	

Mechanical	Dry	Unit	Test Method
Tensile Stress (Break)	210	MPa	ASTM D-638
Tensile Strain (Break)	3.5	%	ASTM D-638
Flexural Strength	350	MPa	ASTM D-790
IZOD Impact Strength (23°C)			
Notch	125	J/m	ASTM D-256A
Unnotch	1100	J/m	

Thermal	Dry	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa Unannealed	250	°C	ASTM D-648
1.8 MPa Unannealed	245	°C	ASTM D-648

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Injection Molding – XU6250GY01

Drying Conditions

Drying Time(hour)	Temperature	Remarks
3-4	85-90°C	Temperature should not be more than 90°C to avoid discoloration Moisture content after drying should be <0.2% Avoid sudden cooling of dry pellet

Injection Molding Temperatures (°C)				
Mold	Melt	Nozzle	Centre	Feed zone
55 – 80	275 – 285	270 -280	285 -295	275-285

Physical form and storage

ESTOPLAST XU is supplied in pellet form. It should be pre-dried as per the guideline mentioned above prior to molding. Standard packing size is 25kg. In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged.

Product Safety

ESTOPLAST XU is thermally stable up to 400°C and does not give rise to hazardous material due to degradation or evolution of gases and vapors. ESTOPLAST XU decomposes above 350°C and gives carbon dioxide and water on charring.
For more information on safety, refer individual product MSDS. Available on request.

Note

All information supplied in this publication is based on our current knowledge and experience. The data provided fall within the normal range of product properties and relate only to the specific material designed. The data provided should not be used to establish specification limits or used alone as the basis of design. ESTER assumes no liability and makes no warranties of any kind, expressed or implied, whatsoever in respect of application, processing or use made of aforementioned information or product.