Product Data Sheet
ESTOPLAST XU6240BB02
[PA66-MF/GF] Compound

Product Description

Polyamide 66 – 40% Mineral/Glass fiber reinforced

Product Applications

Automotive: Fuel Circuit Part, Housing, Electric Motor Part, Exterior trim, interior trim and Electrical components

Electrical & Electronic: Low voltage switch gear/power distribution, Power connectors, MCB, RCCB

General

Material Status	• Commercial : Active
Filler/Reinforcement	• MF/GF, 40%
Forms	• Pellets
Additive	• Mold Release
Feature	• Non FR
Appearance/Color	• Black
Processing Method	• Injection molding

	Typical Value	Unit	Test Method
Density	1.48	gm/cm^3	ISO 1183
Water Absorption Saturation, 23°C Equilibrium, 23°C, 50%RH	 4.5 1.3	 % %	 ISO 62

Mechanical	Typical Value	Unit	Test Method
Tensile Stress at Break	117	MPa	ISO 527
Tensile Strain at Break	3.0	%	ISO 527
Flexural Strength	185	MPa	ISO 178
IZOD Impact Strength (23°C) Notch Unnotch	 5 51	 KJ/m^2 KJ/m^2	 ISO 180 ISO 180

Thermal	Typical Value	Unit	Test Method
Heat Deflection Temperature 0.45 MPa Unannealed 1.8 MPa Unannealed	 245 230	 °C °C	 ISO 75 ISO 75

Flammability	Typical Value	Unit	Test Method
Flammability Classification 1.50 mm	 HB	 Rating	 UL94

Electrical	Typical Value	Unit	Test Method
Volume Resistivity	10^{14}	Ohm cm	IEC 60093
Surface Resistivity, ROA	10^{13}	Ohm	IEC 60093

Injection Molding – XU6240BB02

Drying Conditions

Drying Time(hour)	Temperature	Remarks
3-4	80-90°C	Increase Temperature 10-20 °C or Drying time 1-2 hrs if required. 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	280 -290	280 -295	270-285

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

Note

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