

FRIANYL® A3 GF30 V0 OR 2003/T

Polyamide 66 compound, 30% glass fiber reinforced, heat resistant, based on flame retardants halogen and red phosphorous free. UL listed V0@0.4mm all color.

Designed for Electrical applications requiring self-extinguishing properties combined with good mechanical performances, this grade meets the most stringent safety requirements for insulating materials.

Rheological properties

Melt volume-flow rate	50 cm ³ /10min	ISO 1133
Temperature	275 °C	
Load	5 kg	

Typical mechanical properties

	dry/cond.		
Tensile Modulus	10000 / -	MPa	ISO 527-1/-2
Stress at break, 5mm/min	135 / -	MPa	ISO 527-1/-2
Strain at break, 5mm/min	2 / -	%	ISO 527-1/-2
Charpy notched impact strength, 23°C	6.5 / -	kJ/m ²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	260 °C	ISO 11357-1/-3
-------------------------------	--------	----------------

Flammability

Burning Behav. at thickness h	V-0 class	UL 94
Thickness tested	0.4 mm	UL 94
UL recognition	yes	UL 94

Other properties

Density	1430 kg/m ³	ISO 1183
---------	------------------------	----------

Characteristics

Additives	Non-halogenated/Red phosphorous free flame retardant
-----------	--

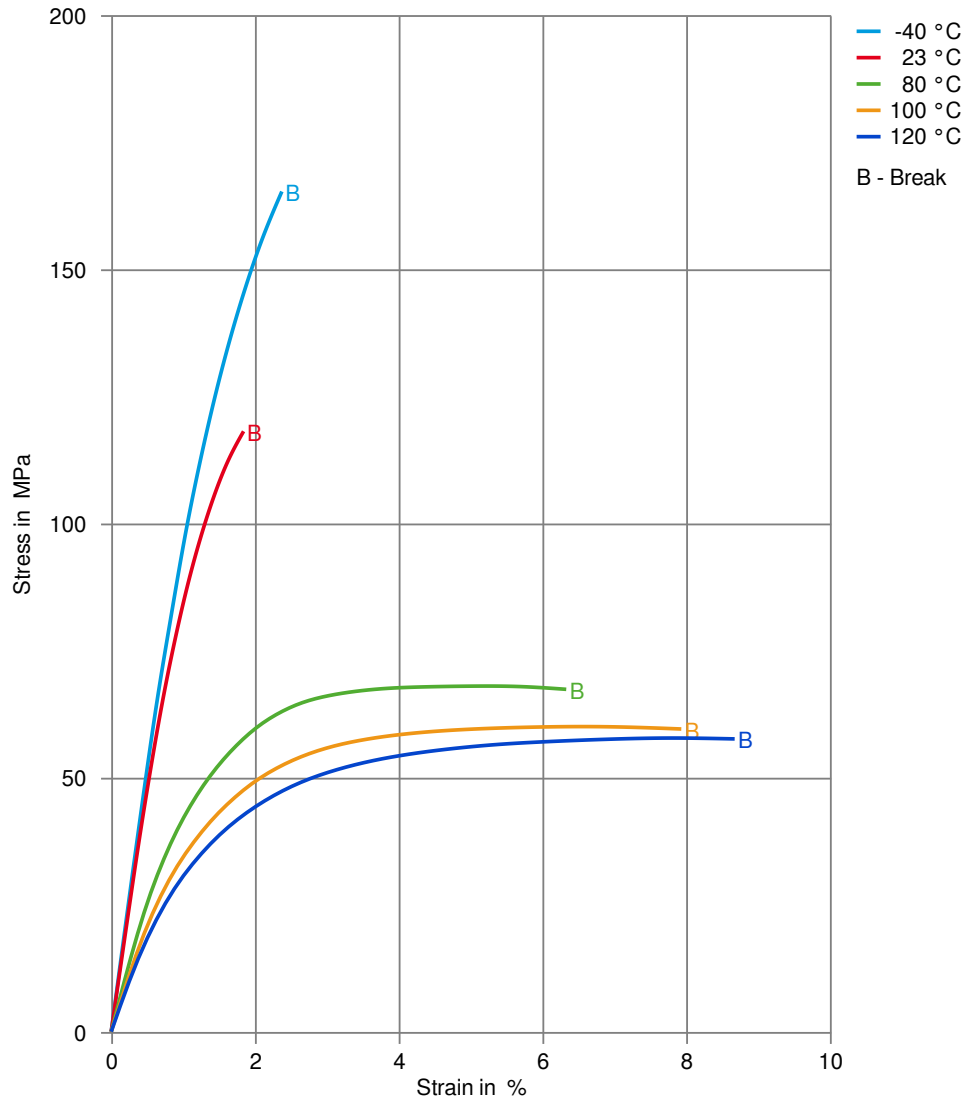
Additional information

Injection molding	<p>The following conditions apply to a standard injection molding process. Machine temperatures: barrel 265-290°C (PA66), 235-270°C (PA6), nozzle and hot runners up to 300°C (up to 290°C products with flame retardants). Mold temperatures: 60-80°C, (80-100°C highly reinforced grades). Back pressure: typically, 5-10 bar (hydraulic pressure). Temperatures exceeding 300°C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the molded part characteristics. For further details, please refer to the document 'Instructions for injection molding' or contact our technical support team.</p>
-------------------	---



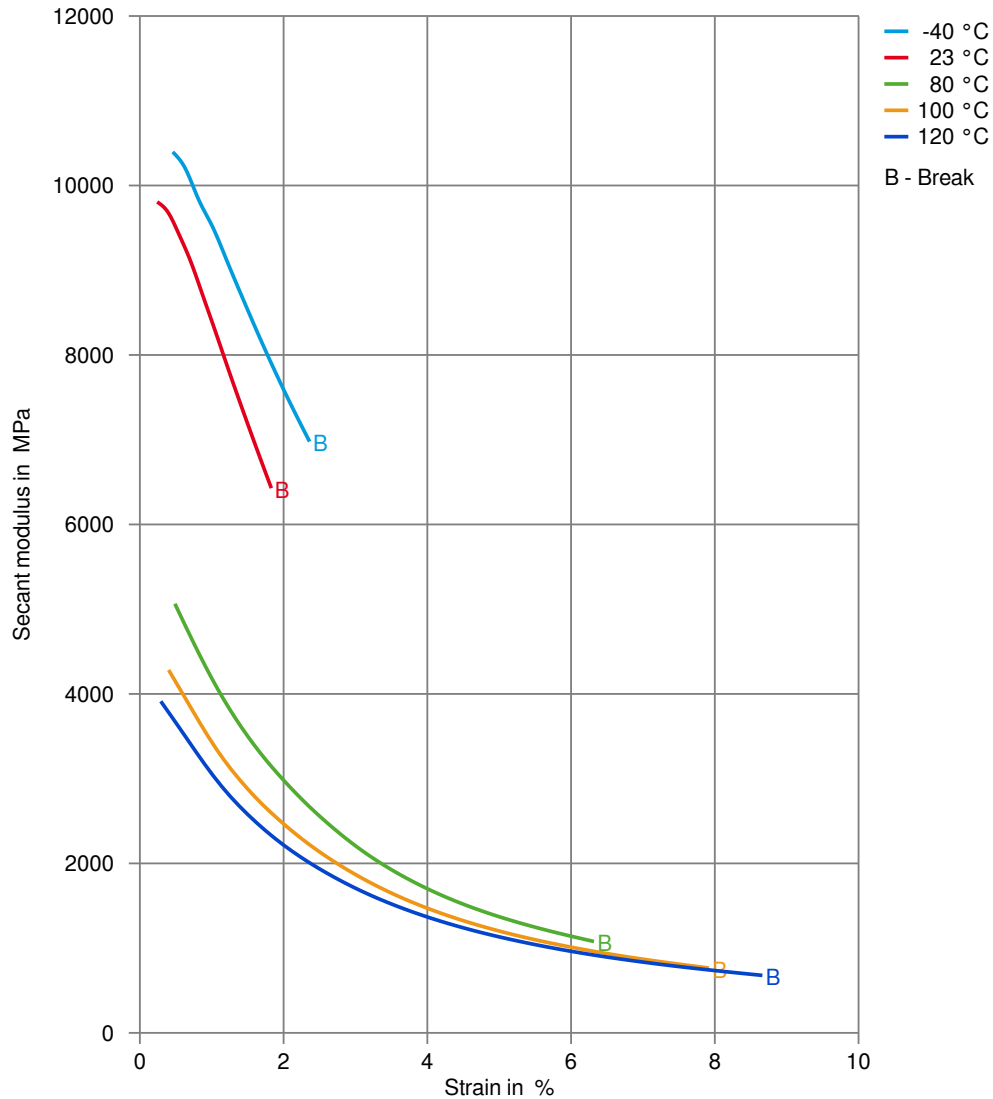
FRIANYL® A3 GF30 V0 OR 2003/T

Stress-strain (dry)



FRIANYL® A3 GF30 V0 OR 2003/T

Secant modulus-strain (dry)



FRIANYL® A3 GF30 V0 OR 2003/T

Processing Texts

Injection molding

The following conditions apply to a standard injection molding process. Machine temperatures: barrel 265-290°C (PA66), 235-270°C (PA6), nozzle and hot runners up to 300°C (up to 290°C products with flame retardants). Mold temperatures: 60-80°C, (80-100°C highly reinforced grades). Back pressure: typically, 5-10 bar (hydraulic pressure). Temperatures exceeding 300°C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the molded part characteristics. For further details, please refer to the document 'Instructions for injection molding' or contact our technical support team.

Injection molding Preprocessing

PA materials, stocked in a moisture-proof packaging, can be processed without drying; however, it is always recommended drying the product that comes from a large package (e.g. Octabin). The moisture content suggested for the injection molding process should be lower than 0.15%, according to the grade and to the molded part characteristics. The materials containing flame retardants should have moisture content below 0.10%. Red phosphorous containing grades must always be dried below 0.08%. The drying time depends on the moisture content and the drying conditions. Typically, 4-8 hours at 80-90°C using dehumidified air (dew point of -20°C) are suitable conditions for a starting moisture content of 0.20%-0.40%.

Injection molding Postprocessing

PA materials reach their final performance with a water content of about 1.5 to 3.5% by weight, depending on the type. This percentage corresponds to the point of equilibrium between the rates of absorption and desorption of moisture. After molding, in favorable environmental conditions, a part can quickly absorb moisture up to 0.5-1.0%, while the equilibrium will be reached during its life. A conditioning treatment can accelerate further the initial water absorption of the molded parts. Conditioning is usually carried out in hot and humid environment (for example 50°C, 100% RH), inside climatic chambers. Slight dimensional variations (increase in volume due to the water absorbed) must be considered, especially in unfilled grades. Post-treatments of parts may also include the annealing (60-80°C in oven, up to four hours). This procedure can be useful to relax any internal stresses.

Other Approvals

Other Approvals

OEM	Specification	Additional Information
VW Group*	VW50133	* best fitting grade to PA66-6-A, not officially approved
Renault	UB22a	



FRIANYL® A3 GF30 V0 OR 2003/T

Renault	UB22b	
Renault	UB22c	
Renault	UB22d	

