

Technical Data Sheet



ALTECH PA66 A 1000/109 BK1008-13LS

MOCOM

Base Polymer	Polyamide 66
Filler/Additive System	laser optimisation, Laser sensitive additive
Colour	black
Special Features	heat stabilised, easy release (demoulding), easy flow, laser etchable (light etching)
Market Segment	Automotive, electrical and electronic
Application Area	injection moulded parts, interior decoration / finishing, electrical and electronic (E&E), electrical components

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
Mechanical Properties			
Flexural Modulus	3300 / -	MPa	ISO 178
Flexural Stress (3.5% Strain)	100 / -	MPa	ISO 178
Tensile Modulus	3300 / -	MPa	ISO 527
Tensile Strength	80 / -	MPa	ISO 527
Tensile Elongation at Break	3.5 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	30 / -	kJ/m²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	25 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	3 / -	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	2 / -	kJ/m²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	80 / *	°C	ISO 75-1/-2
DSC (Melt Point)	263 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	1.2 - 1.6	%	ISO 294-4
Shrinkage (lateral, 24h)	1.8 - 2.2	%	ISO 294-4
Physical Properties			
Density	1130 / -	kg/m³	ISO 1183
Flammability			
Flammability (0.75 mm)	HB / *	class	UL 94
Yellow Card available	yes / *	-	-