

Heramid® A NER GF030/1K

Polyamide 66

Radici Plastics

Message:

PA66 30% glass fiber reinforced injection moulding grade. Heat stabilized. Black colour.

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

ISO 1043 : PA66-T GF30

General Information				
Filler / Reinforcement	Glass Fiber,30% Filler by Weight			
Additive	Heat Stabilizer			
Features	Heat Stabilized			
RoHS Compliance	RoHS Compliant			
Appearance	Black			
Processing Method	Injection Molding			
Resin ID (ISO 1043)	PA66-T GF30			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8500	6500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	130	85.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	2.5	%	ISO 527-2/1A/5
Flexural Modulus ¹	7500	4000	MPa	ISO 178
Flexural Stress ²	200	130	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.5	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	40	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	220	--	°C	ISO 75-2/Af
Vicat Softening Temperature	225	--	°C	ISO 306/B50
Melting Temperature ³	262	--	°C	ISO 11357
Flammability	Dry	Conditioned	Test Method	
Flame Rating (0.800 mm)	HB	--	UL 94	
Injection	Dry	Unit		
Drying Temperature - Desiccant Dryer	80.0		°C	
Drying Time - Desiccant Dryer	2.0 to 4.0		hr	

Dew Point - Desiccant Dryer	< -20.0	°C
Suggested Max Moisture	0.15	%
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	80.0 to 100	°C
Injection Rate	Moderate-Fast	

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	10°C/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

