

FRIANYL® A3 V2XI - PA66
Description

Polyamide 66 compound, heat stabilized, unfilled, flame retardant with halogens PBB and PBDE free. UL listed V2@0.4mm.
 Designed for Electrical applications requiring self-extinguishing properties combined with ignition resistance, this grade meets the most stringent safety requirements for insulating materials for the household appliance industry.

Physical properties	Value	Unit	Test Standard
Density	1330	kg/m ³	ISO 1183
Molding shrinkage, parallel (flow)	0.8 - 1.2	%	ISO 294-4, 2577
Molding shrinkage, transverse normal	0.8 - 1.2	%	ISO 294-4, 2577
Water absorption, 23°C-sat	6	%	Sim. to ISO 62
Humidity absorption, 23°C/50%RH	1	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	3550/-	MPa	ISO 527-1, -2
Tensile stress at break, 5mm/min	60/-	MPa	ISO 527-1, -2
Tensile strain at break, 5mm/min	4.3/-	%	ISO 527-1, -2
Flexural modulus, 23°C	2700/-	MPa	ISO 178
Flexural stress at max. force	110/-	MPa	ISO 178
Charpy impact strength, 23°C	65/-	kJ/m ²	ISO 179/1eU
Izod impact notched, 23°C	4.4/-	kJ/m ²	ISO 180/1A
Izod impact unnotched, 23°C	44/-	kJ/m ²	ISO 180/1U

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	100	°C	ISO 75-1, -2
DTUL at 0.45 MPa	235	°C	ISO 75-1, -2
FMVSS	SE	-	ISO 3795 (FMVSS 302)
Flammability @3.2mm nom. thickn.	V-2	class	UL 94
Flammability @1.6mm nom. thickn.	V-2	class	UL 94
Flammability @0.8mm nom. thickn.	V-2	class	UL 94
Flammability @0.4mm nom. thickn.	V-2	class	UL 94
Continuous service temperature	110	°C	DIN/IEC 60216-1
Glow wire ignition temperature, 0.8 mm	875	°C	IEC 60695-2-13
Glow wire ignition temperature, 1.0 mm	900	°C	IEC 60695-2-13
Glow wire ignition temperature, 3.2 mm	900	°C	IEC 60695-2-13
Glow wire flammability index, 0.8 mm	850	°C	IEC 60695-2-12
Glow wire flammability index, 1.0 mm	960	°C	IEC 60695-2-12
Glow wire flammability index, 3.2 mm	960	°C	IEC 60695-2-12
Ball pressure test	230	°C	IEC 60695-10-2
RTI - electrical @ 0.8mm nom. Thickn.	140	°C	UL 746B
RTI - electrical @ 1.6mm nom. Thickn.	140	°C	UL 746B
RTI - electrical @ 3.2mm nom. Thickn.	140	°C	UL 746B
RTI - impact @ 0.8mm nom. Thickn.	90	°C	UL 746B
RTI - impact @ 1.6mm nom. Thickn.	90	°C	UL 746B
RTI - impact @ 3.2mm nom. Thickn.	90	°C	UL 746B
RTI - str @ 0.8mm nom. Thickn.	115	°C	UL 746B
RTI - str @ 1.6mm nom. Thickn.	115	°C	UL 746B
RTI - str @ 3.2mm nom. Thickn.	115	°C	UL 746B

Electrical properties	Value	Unit	Test Standard
Comparative tracking index	PLC 1/-	-	UL 746
Comparative tracking index CTI 50 drops	Group IIIa 375	- V	IEC 60112 IEC 60112
Hot wire ignition @ 0.8mm nom. Thickn.	PLC 0	class	UL 746A
Hot wire ignition @ 1.6mm nom. Thickn.	PLC 0	class	UL 746A
Hot wire ignition @ 3.2mm nom. Thickn.	PLC 0	class	UL 746A

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High ampere arc ignition @ 0.8mm nom. Thickn.

PLC 0 class UL 746A

High ampere arc ignition @ 1.6mm nom. Thickn.

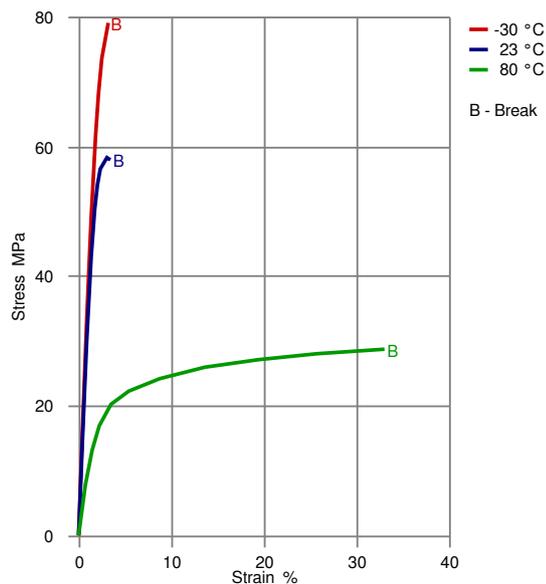
PLC 0 class UL 746A

High ampere arc ignition @ 3.2mm nom. Thickn.

PLC 0 class UL 746A

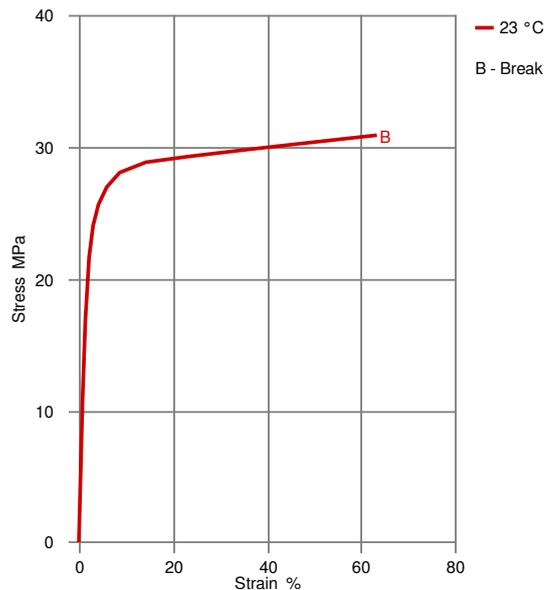
Diagrams

Stress-strain (dry)



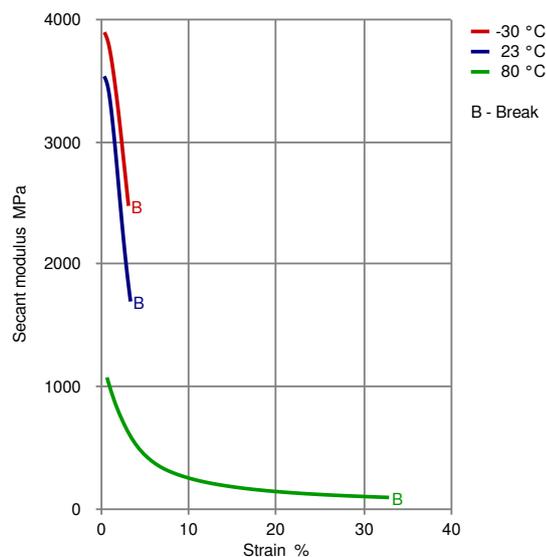
Dry samples are dry as molded
Conditioned sample is conditioned according to ISO 1110

Stress-strain (cond.)

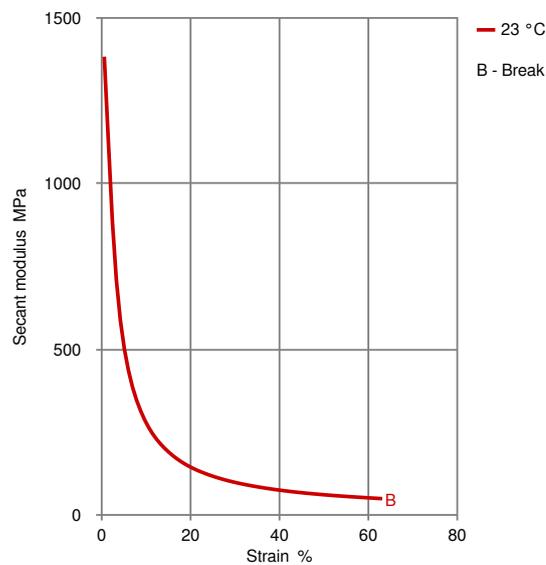


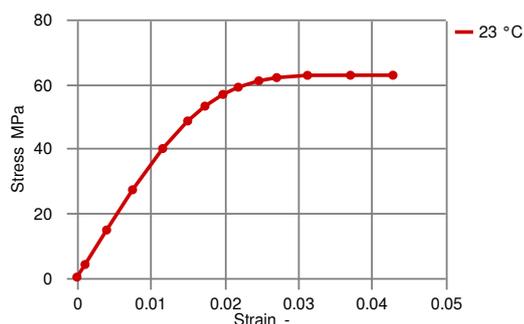
Dry samples are dry as molded
Conditioned sample is conditioned according to ISO 1110

Secant modulus-strain (dry)



Secant modulus-strain (cond.)



True Stress-strain (dry)

dry sample is dry as molded
23 °C yield at 0.03132 strain, 62.627 stress
Poisson ratio used: 0.38

Other text information**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

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 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.

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Characteristics

Special Characteristics	Flame retardant, Heat resistant
Product Categories	Unfilled
Processing	Injection molding
Delivery Form	Granules
Additives	Flame retarding agent

Contact

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General Disclaimer

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