

RamLloy PNA810G2BK10

(PPE+PA*)-GF10

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	20	g/10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4050	MPa	ISO 527
Tensile Strength	95	MPa	ISO 527
Strain at break	4.4	%	ISO 527
Flexural modulus, 23°C	3700	MPa	ISO 178
Flexural strength	145	MPa	ISO 178
Izod notched impact strength, +23°C	9	kJ/m ²	ISO 180/1A
Izod notched impact strength	6	kJ/m ²	ISO 180/1A
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	195	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	230	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	3.5	%	Sim. to ISO 62
Density	1160	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	80 - 100	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 290	°C	-
Zone 3	280 - 300	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Black

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa