

**PlusTek PB828J42BR22**

PA6-(GF+GB)42

Polyram

| Processing/Physical Characteristics | Value | Unit | Test Standard   |
|-------------------------------------|-------|------|-----------------|
| <b>ISO Data</b>                     |       |      |                 |
| Molding shrinkage, parallel         | 0.2   | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal           | 0.6   | %    | ISO 294-4, 2577 |

| Mechanical properties               | Value | Unit              | Test Standard |
|-------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                     |       |                   |               |
| Tensile Modulus                     | 10200 | MPa               | ISO 527       |
| Tensile Strength                    | 135   | MPa               | ISO 527       |
| Strain at break                     | 2.7   | %                 | ISO 527       |
| Izod notched impact strength, +23°C | 19    | kJ/m <sup>2</sup> | ISO 180/1A    |

| Other properties    | Value | Unit              | Test Standard  |
|---------------------|-------|-------------------|----------------|
| Water absorption    | 5     | %                 | Sim. to ISO 62 |
| Humidity absorption | 1.5   | %                 | Sim. to ISO 62 |
| Density             | 1430  | kg/m <sup>3</sup> | ISO 1183       |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 80        | °C   | -             |
| Pre-drying - Time                           | 4 - 8     | h    | -             |
| Processing humidity                         | ≤0.15     | %    | -             |
| Mold temperature                            | 55 - 90   | °C   | -             |
| Feed temperature                            | 60 - 80   | °C   | -             |
| Zone 1                                      | 230 - 240 | °C   | -             |
| Zone 2                                      | 230 - 240 | °C   | -             |
| Zone 3                                      | 230 - 270 | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Brown

**Special Characteristics**

High impact or impact modified

**Certifications**

RoHS compliant

**Regional Availability**

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