

PlusTek PB830G14BK10

PA6-GF14

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4700	MPa	ISO 527
Tensile Strength	100	MPa	ISO 527
Strain at break	4.7	%	ISO 527
Charpy impact strength, +23°C	72	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	23	kJ/m ²	ISO 179/1eA
Izod notched impact strength	14	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	180	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	208	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	6.5	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1170	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	55 - 90	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	220 - 240	°C	-
Zone 2	220 - 240	°C	-
Zone 3	230 - 270	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Black

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Regional Availability

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