

**PlusTek PB830G14BK10-B**

PA6-GF14

Polyram

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

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	5150	MPa	ISO 527
Tensile Strength	100	MPa	ISO 527
Strain at break	4	%	ISO 527
Charpy impact strength, +23°C	72	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	21.5	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength	12	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
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 <sup>3</sup>	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