

PlusTek PB324G5BL210

PA6-GF25

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	165	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Izod notched impact strength, +23°C	11.5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.6	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	7	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1550	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.1	%	-
Mold temperature	80 - 100	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	250 - 270	°C	-
Zone 2	260 - 280	°C	-
Zone 3	270 - 285	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant

Certifications

RoHS compliant

Regional Availability

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