PlusTek PB366G6BK10

PA6-GF30 Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.3 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.9 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**9650 / 7630**	MPa	ISO 527
Tensile Strength	**175 / 135**	MPa	ISO 527
Strain at break	**2.9 / 3**	%	ISO 527
Flexural modulus, 23°C	**8900 / 5750**	MPa	ISO 178
Flexural strength	**280 / 198**	MPa	ISO 178
Charpy impact strength, +23°C	**80 / -**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**11 / -**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**14 / 21.5**	kJ/m²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**203 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**216 / ***	°C	ISO 75-1/-2
Burning rate, FMVSS, Thickness 1 mm	**100**	mm/min	ISO 3795 (FMVSS 302)

Other properties	dry / cond	Unit	Test Standard
Density	**1360 / -**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Processing humidity	**≤0.15**	%	-
Mold temperature	**65 - 80**	°C	-
Feed temperature	**60 - 70**	°C	-
Zone 1	**240 - 280**	°C	-
Zone 2	**240 - 280**	°C	-
Zone 3	**240 - 280**	°C	-

Characteristics

Processing
Injection Molding

Special Characteristics
Heat stabilized or stable to heat

Delivery form
Black

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