

**PlusTek PB827G6OR45**

PA6-GF30

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	8500	MPa	ISO 527
Tensile Strength	129	MPa	ISO 527
Strain at break	5.9	%	ISO 527
Izod notched impact strength, +23°C	30.5	kJ/m <sup>2</sup>	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	7	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1300	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

**Special Characteristics**

High impact or impact modified, U.V. stabilized or stable to weather

**Regional Availability**

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