

PlusTek PB302G50GR215

PA6-GF50

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.1	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	17000	MPa	ISO 527
Tensile Strength	190	MPa	ISO 527
Strain at break	2.2	%	ISO 527
Izod notched impact strength, +23°C	12	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	5	%	Sim. to ISO 62
Humidity absorption	1.5	%	Sim. to ISO 62
Density	1550	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.15	%	-
Mold temperature	90 - 95	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	290 - 300	°C	-
Zone 2	290 - 300	°C	-
Zone 3	290 - 300	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather

Certifications

RoHS compliant

Regional Availability

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