

PlusTek PB391G50BK10

PA6-GF50

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	16800	MPa	ISO 527
Tensile Strength	220	MPa	ISO 527
Strain at break	2.1	%	ISO 527
Flexural modulus, 23°C	13500	MPa	ISO 178
Flexural strength	365	MPa	ISO 178
Charpy notched impact strength, +23°C	16	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	15.5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	209	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	216	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	6	%	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 - 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

Delivery form

Black

Certifications

Food contact, Food approval 10/2011

Regional Availability

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