

Polyramid BRV50 BK10

PA6-GF50

Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.7 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	12000 / 8000	MPa	ISO 527
Tensile Strength	185 / 125	MPa	ISO 527
Strain at break	2.5 / 4.5	%	ISO 527
Flexural modulus, 23°C	12500 / 8500	MPa	ISO 178
Flexural strength	265 / -	MPa	ISO 178
Charpy impact strength, +23°C	50 / -	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	35 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	14 / -	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	9 / -	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	12 / 16	kJ/m ²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	195 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1560 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	80 - 90	°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

Delivery form

Black

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

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