

PlusTek PB360G60BK10

PA6-GF60

Polyram

| Processing/Physical Characteristics | dry / cond | Unit | Test Standard |
|-------------------------------------|------------|------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.2 / * | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.3 / * | % | ISO 294-4, 2577 |

| Mechanical properties | dry / cond | Unit | Test Standard |
|---------------------------------------|---------------|-------------------|---------------|
| ISO Data | | | |
| Tensile Modulus | 22400 / 17400 | MPa | ISO 527 |
| Tensile Strength | 240 / 185 | MPa | ISO 527 |
| Strain at break | 2.1 / 2 | % | ISO 527 |
| Flexural modulus, 23°C | 19600 / 17200 | MPa | ISO 178 |
| Flexural strength | 395 / 327 | MPa | ISO 178 |
| Charpy impact strength, +23°C | 80 / - | 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 | 14.5 / - | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 19.5 / 21 | kJ/m ² | ISO 180/1A |

| Thermal properties | dry / cond | Unit | Test Standard |
|--|------------|--------|----------------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 213 / * | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 220 / * | °C | ISO 75-1/-2 |
| Burning behav. at thickness h | HB / * | class | IEC 60695-11-10 |
| Thickness tested | 3.0 / * | mm | - |
| Burning rate, FMVSS, Thickness 1 mm | 100 | mm/min | ISO 3795 (FMVSS 302) |

| Other properties | dry / cond | Unit | Test Standard |
|---------------------|------------|-------------------|----------------|
| Water absorption | 4.4 / * | % | Sim. to ISO 62 |
| Humidity absorption | 1.2 / * | % | Sim. to ISO 62 |
| Density | 1720 / - | kg/m ³ | 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

Features

Homopolymer

Delivery form

Black

Regional Availability

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

Special Characteristics

Heat stabilized or stable to heat