

**PlusTek RA325J5BK27**

PA66-(GF+GB)25

Polyram

| <b>Mechanical properties</b>        | <b>Value</b> | <b>Unit</b>       | <b>Test Standard</b> |
|-------------------------------------|--------------|-------------------|----------------------|
| <b>ISO Data</b>                     |              |                   |                      |
| Tensile Modulus                     | <b>6200</b>  | MPa               | ISO 527              |
| Tensile Strength                    | <b>98</b>    | MPa               | ISO 527              |
| Strain at break                     | <b>3.1</b>   | %                 | ISO 527              |
| Izod notched impact strength, +23°C | <b>4.2</b>   | kJ/m <sup>2</sup> | ISO 180/1A           |

| <b>Thermal properties</b>                                 | <b>Value</b>             | <b>Unit</b> | <b>Test Standard</b> |
|---|--------------------------|-------------|----------------------|
| <b>ISO Data</b>   |                          |             |                      |
| Burning behav. at 1.5 mm nom. thickn.<br>Thickness tested | <b>V-0</b><br><b>1.6</b> | class<br>mm | IEC 60695-11-10<br>- |
| Burning behav. at thickness h<br>Thickness tested         | <b>V-0</b><br><b>0.8</b> | class<br>mm | IEC 60695-11-10<br>- |
| Glow Wire Flammability Index (GWFI)                       | <b>960</b>               | °C          | IEC 60695-2-12       |
| GWFI - thickness tested (1)                               | <b>1.6</b>               | mm          | -                    |
| <b>ASTM Data</b>  |                          |             |                      |
| UL 94 Flame rating<br>Thickness tested                    | <b>V-0</b><br><b>3</b>   | -<br>mm     | UL 94<br>-           |
| Vicat Temperature   | <b>250</b>               | °C          | ASTM D 1525          |

| <b>Other properties</b> | <b>Value</b> | <b>Unit</b>       | <b>Test Standard</b> |
|-------------------------|--------------|-------------------|----------------------|
| Density                 | <b>1380</b>  | kg/m <sup>3</sup> | ISO 1183             |

| <b>Processing Recommendation Injection Molding</b> | <b>Value</b>     | <b>Unit</b> | <b>Test Standard</b> |
|--|------------------|-------------|----------------------|
| Pre-drying - Temperature                           | <b>80</b>        | °C          | -                    |
| Pre-drying - Time                                  | <b>3 - 4</b>     | h           | -                    |
| Processing humidity                                | <b>≤0.15</b>     | %           | -                    |
| Mold temperature                                   | <b>70 - 90</b>   | °C          | -                    |
| Feed temperature                                   | <b>60 - 80</b>   | °C          | -                    |
| Zone 1   | <b>260 - 270</b> | °C          | -                    |
| Zone 2   | <b>270 - 280</b> | °C          | -                    |
| Zone 3   | <b>270 - 290</b> | °C          | -                    |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

Flame retardant, Halogen-free

**Certifications**

RoHS compliant

**Applications**

Electrical and Electronical

**Regional Availability**

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