

**PlusTek PA4802G6BK10**

(PA66+PTFE)-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	9950	MPa	ISO 527
Tensile Strength	160	MPa	ISO 527
Strain at break	2.5	%	ISO 527
Flexural modulus, 23°C	8100	MPa	ISO 178
Flexural strength	250	MPa	ISO 178
Izod notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	246	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	260	°C	ISO 75-1/-2
<b>Other properties</b>			
Water absorption	5.5	%	Sim. to ISO 62
Humidity absorption	1.5	%	Sim. to ISO 62
Density	1480	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	80 - 90	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	260 - 280	°C	-
Zone 2	260 - 280	°C	-
Zone 3	280 - 300	°C	-

**Characteristics****Processing**

Injection Molding

**Certifications**

RoHS compliant

**Delivery form**

Black

**Regional Availability**

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

**Additives**

Lubricants