RAVAMID® A GB30 BK45

PA66-GB30 Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	**0.009**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**4500**	MPa	ISO 527
Yield stress	**60**	MPa	ISO 527
Stress at break	**55**	MPa	ISO 527
Strain at break	**8**	%	ISO 527
Flexural modulus, 23°C	**4400**	MPa	ISO 178
Charpy impact strength, +23°C	**35**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**6.5**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**6.5**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**85**[ann.]	°C	ISO 75-1/-2
Vicat softening temperature, B	**240**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.6**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**3.2**	mm	-
Burning rate, FMVSS, Thickness 1 mm	**100**	mm/min	ISO 3795 (FMVSS 302)
Glow Wire Flammability Index (GWFI)	**650**	°C	IEC 60695-2-12
GWFI - thickness tested (1)	**2**	mm	-

ann.: annealed

Other properties	Value	Unit	Test Standard
Humidity absorption	**0.15**	%	Sim. to ISO 62
Density	**1350**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**85**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.12**	%	-
Melt temperature	**270 - 290**	°C	-
Mold temperature	**70 - 90**	°C	-
Zone 1	**250 - 260**	°C	-
Zone 2	**260 - 270**	°C	-
Zone 3	**280 - 290**	°C	-
Nozzle temperature	**280 - 285**	°C	-
Screw speed	**50 - 80**	rpm	-
Back pressure	**0.4 - 0.8**	MPa	-
Holding pressure	**6 - 8**	MPa	-

Characteristics

Processing
Injection Molding

Regional Availability
Europe

Delivery form
Black