

**PlusTek PA840G13BK10**

PA66-GF13

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	5100	MPa	ISO 527
Tensile Strength	105	MPa	ISO 527
Yield strain	3.4	%	ISO 527
Strain at break	3.8	%	ISO 527
Izod notched impact strength, +23°C	9.2	kJ/m <sup>2</sup>	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	6.5	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1200	kg/m <sup>3</sup>	ISO 1183

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

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

High impact or impact modified

**Certifications**

RoHS compliant

**Regional Availability**

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