

PlusTek PA840G3BL111

PA66-GF15

Polyram

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

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	5100	MPa	ISO 527
Tensile Strength	93	MPa	ISO 527
Strain at break	3.6	%	ISO 527
Izod notched impact strength, +23°C	9	kJ/m ²	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 ³	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

Certifications

RoHS compliant

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather

Regional Availability

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