

PlusTek RA325G5BK10-M

PA66-GF25

Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8800 / 6560	MPa	ISO 527
Tensile Strength	135 / 101	MPa	ISO 527
Strain at break	2.7 / 2.8	%	ISO 527
Flexural modulus, 23°C	7400 / 4620	MPa	ISO 178
Flexural strength	200 / 156	MPa	ISO 178
Charpy impact strength, +23°C	53 / -	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	51 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	9 / -	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	6.5 / -	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10 / -	kJ/m ²	ISO 180/1A
Izod notched impact strength	7.5 / -	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	240 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	258 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Burning behav. at thickness h	V-0 / *	class	IEC 60695-11-10
Thickness tested	3.0 / *	mm	-
Burning behav. 5V at thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.6 / *	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.6	mm	-

Other properties	dry / cond	Unit	Test Standard
Water absorption	4 / *	%	Sim. to ISO 62
Humidity absorption	1.2 / *	%	Sim. to ISO 62
Density	1350 / -	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	70 - 120	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	250 - 270	°C	-
Zone 2	265 - 290	°C	-
Zone 3	265 - 290	°C	-

Characteristics**Processing**

Injection Molding

Certifications

RoHS compliant

Delivery form

Black

Applications

Automotive

Special Characteristics

Flame retardant, Halogen-free

Regional Availability

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