

Polyramid ARV30 BK10

PA66-GF30

Polyram

| Processing/Physical Characteristics | dry / cond | Unit | Test Standard |
|-------------------------------------|------------|------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.7 / * | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.9 / * | % | ISO 294-4, 2577 |

| Mechanical properties | dry / cond | Unit | Test Standard |
|---------------------------------------|-------------|-------------------|---------------|
| ISO Data | | | |
| Tensile Modulus | 8700 / 6200 | MPa | ISO 527 |
| Tensile Strength | 145 / 85 | MPa | ISO 527 |
| Strain at break | 2.5 / 4.1 | % | ISO 527 |
| Flexural modulus, 23°C | 7000 / 5000 | MPa | ISO 178 |
| Flexural strength | 230 / 125 | MPa | ISO 178 |
| Charpy impact strength, +23°C | 8 / - | kJ/m ² | ISO 179/1eU |
| Charpy impact strength, -30°C | 368 / - | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 45 / - | kJ/m ² | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 6 / - | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 7.8 / 14 | kJ/m ² | ISO 180/1A |

| Thermal properties | dry / cond | Unit | Test Standard |
|--|------------|-------|-----------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 235 / * | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 240 / * | °C | ISO 75-1/-2 |
| Burning behav. at 1.5 mm nom. thickn. | HB / * | class | IEC 60695-11-10 |
| Thickness tested | 1.6 / * | mm | - |

| Other properties | dry / cond | Unit | Test Standard |
|---------------------|------------|-------------------|----------------|
| Humidity absorption | 0.8 / * | % | Sim. to ISO 62 |
| Density | 1370 / - | kg/m ³ | ISO 1183 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|-----------|------|---------------|
| 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

Special Characteristics

Heat stabilized or stable to heat

Delivery form

Black

Regional Availability

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