

PlusTek PA870G33BK11

PA66-GF33

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	9100	MPa	ISO 527
Tensile Strength	135	MPa	ISO 527
Strain at break	3	%	ISO 527
Izod notched impact strength	22.5	kJ/m ²	ISO 180/1A
ASTM Data			
Izod Impact notched, 1/8 in	215	J/m	ASTM D 256

Other properties	Value	Unit	Test Standard
Water absorption	6.5	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1330	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

Delivery form

Black

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