

**PlusTek PA7800G33BK11**

PA66-GF33

Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	9490 / 7100	MPa	ISO 527
Tensile Strength	155 / 115	MPa	ISO 527
Strain at break	3.6 / 4	%	ISO 527
Flexural modulus, 23°C	8700 / -	MPa	ISO 178
Flexural strength	210 / -	MPa	ISO 178
Charpy notched impact strength, +23°C	20 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	23 / 27	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Shore D Hardness	85 / -	-	ASTM D 2240

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	51 / *	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.80 MPa	240 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	257 / *	°C	ISO 75-1/-2
Burning rate, FMVSS, Thickness 1 mm	100	mm/min	ISO 3795 (FMVSS 302)
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	3	mm	-

Other properties	dry / cond	Unit	Test Standard
Water absorption	5 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1330 / -	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.15	%	-
Mold temperature	60 - 90	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	260 - 270	°C	-
Zone 2	260 - 270	°C	-
Zone 3	260 - 270	°C	-

**Characteristics****Processing**

Injection Molding

**Certifications**

RoHS compliant

**Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Regional Availability**

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