

PlusTek RA300G33BK10

PA66-GF33

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	11300	MPa	ISO 527
Tensile Strength	179	MPa	ISO 527
Strain at break	2.5	%	ISO 527
Flexural modulus, 23°C	9000	MPa	ISO 178
Flexural strength	230	MPa	ISO 178
Izod notched impact strength, +23°C	9.2	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	220	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	250	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
Vicat Temperature	180	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water absorption	6	%	Sim. to ISO 62
Humidity absorption	2.1	%	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	3 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	70 - 120	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 300	°C	-
Zone 3	280 - 300	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Black

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

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