

**PlusTek PA317G9BK10**

PA66-GF45

Polyram

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	0.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4 / *	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	13900 / 10500	MPa	ISO 527
Tensile Strength	195 / 140	MPa	ISO 527
Strain at break	2.3 / 2.6	%	ISO 527
Flexural modulus, 23°C	12700 / -	MPa	ISO 178
Flexural strength	280 / -	MPa	ISO 178
Izod notched impact strength, +23°C	16 / 21	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength Temperature	11 / -	kJ/m <sup>2</sup>	ISO 180/1A
	-30	°C	-
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	246 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	260 / *	°C	ISO 75-1/-2
<b>Other properties</b>			
Water absorption	4.5 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1500 / -	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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

**Chemical Resistance**

Hydrolytically Stable

**Delivery form**

Black

**Certifications**

RoHS compliant

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

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