Polyramid ARV50 BK10

PA66-GF50 Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**0.7 / ***	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.8 / ***	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**14000 / 11500**	MPa	ISO 527
Tensile Strength	**190 / 135**	MPa	ISO 527
Strain at break	**2 / 3.5**	%	ISO 527
Flexural modulus, 23°C	**12000 / 9500**	MPa	ISO 178
Flexural strength	**250 / -**	MPa	ISO 178
Charpy impact strength, +23°C	**60 / -**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**30 / -**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**8 / -**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**5 / -**	kJ/m²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**240 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**250 / ***	°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	**1.2 / ***	%	Sim. to ISO 62
Density	**1560 / -**	kg/m³	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