

PlusTek PA860BK11

PA66

Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.8 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	1800 / 900	MPa	ISO 527
Tensile Strength	45 / 40	MPa	ISO 527
Yield strain	5 / -	%	ISO 527
Strain at break	60 / 100	%	ISO 527
Flexural modulus, 23°C	1600 / -	MPa	ISO 178
Flexural strength	60 / -	MPa	ISO 178
Charpy notched impact strength, +23°C	97 / -	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	45 / -	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	86 / 100	kJ/m ²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	55 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	105 / *	°C	ISO 75-1/-2
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	3	mm	-

Other properties	dry / cond	Unit	Test Standard
Water absorption	6.7 / *	%	Sim. to ISO 62
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1060 / -	kg/m ³	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

Delivery form

Black

Regional Availability

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

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather