

**PlusTek PA860NT**

PA66

Polyram

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>3</b>	g/10min	ISO 1133
Temperature	<b>275</b>	°C	-
Load	<b>5</b>	kg	-
Molding shrinkage, parallel	<b>1.8 / *</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	<b>1700 / 920</b>	MPa	ISO 527
Tensile Strength	<b>45 / 45</b>	MPa	ISO 527
Yield strain	<b>5 / -</b>	%	ISO 527
Strain at break	<b>- / 210</b>	%	ISO 527
Flexural modulus, 23°C	<b>1580 / -</b>	MPa	ISO 178
Flexural strength	<b>68 / 28</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>N / -</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>93 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	<b>85 / 93</b>	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	<b>70 / -</b>	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	<b>-30</b>	°C	-

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 0.45 MPa	<b>130 / *</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>253 / *</b>	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	<b>HB / *</b>	class	IEC 60695-11-10
Thickness tested	<b>1.6 / *</b>	mm	-
Burning behav. at thickness h	<b>HB / *</b>	class	IEC 60695-11-10
Thickness tested	<b>3.0 / *</b>	mm	-

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Water absorption	<b>8 / *</b>	%	Sim. to ISO 62
Humidity absorption	<b>2 / *</b>	%	Sim. to ISO 62

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

**Characteristics****Processing**

Injection Molding

**Delivery form**

Natural Color

**Special Characteristics**

High impact or impact modified

**Certifications**

RoHS compliant

**Regional Availability**

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