

PlusTek RA810BK10

PA66

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	1850	MPa	ISO 527
Tensile Strength	48	MPa	ISO 527
Yield strain	53	%	ISO 527
Izod notched impact strength, +23°C	85	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	7	%	Sim. to ISO 62
Humidity absorption	2	%	Sim. to ISO 62
Density	1080	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

Special Characteristics

High impact or impact modified

Delivery form

Black

Regional Availability

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