RAVAMID® A ST BK

PA66 — Ravago Group

Product Texts

Polyamide 66 black containing recycled material, high impact modified also available heat stabilized (H) and UV stabilized (UV).

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**1.1**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.5**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**50**	MPa	ISO 527
Stress at break	**48**	MPa	ISO 527
Strain at break	**20**	%	ISO 527
Flexural modulus, 23°C	**2200**	MPa	ISO 178
Izod notched impact strength, +23°C	**12.5**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**58**	°C	ISO 75-1/-2
Vicat softening temperature, B	**200**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.6**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**3.2**	mm	-
Glow Wire Flammability Index (GWFI)	**650**	°C	IEC 60695-2-12
GWFI - thickness tested (1)	**2**	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	**0.25**	%	Sim. to ISO 62
Density	**1090**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**85**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.12**	%	-
Melt temperature	**270 - 290**	°C	-
Mold temperature	**70 - 90**	°C	-
Zone 1	**250 - 260**	°C	-
Zone 2	**260 - 270**	°C	-
Zone 3	**280 - 290**	°C	-
Nozzle temperature	**280 - 285**	°C	-
Screw speed	**50 - 80**	rpm	-
Back pressure	**0.4 - 0.8**	MPa	-
Holding pressure	**6 - 8**	MPa	-

Characteristics

Processing

Injection Molding

Certifications

Recycled Resin Content

Delivery form

Black

Regional Availability

Europe

Special Characteristics

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