

**PlusTek PB845GR40**

PA6

Polyram

| Processing/Physical Characteristics | Value | Unit | Test Standard   |
|-------------------------------------|-------|------|-----------------|
| <b>ISO Data</b>                     |       |      |                 |
| Molding shrinkage, parallel         | 1.0   | %    | ISO 294-4, 2577 |

| Mechanical properties               | Value | Unit              | Test Standard |
|-------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                     |       |                   |               |
| Tensile Modulus                     | 3200  | MPa               | ISO 527       |
| Tensile Strength                    | 57    | MPa               | ISO 527       |
| Yield strain                        | 4.1   | %                 | ISO 527       |
| Izod notched impact strength, +23°C | 41.5  | kJ/m <sup>2</sup> | ISO 180/1A    |

| Other properties    | Value | Unit              | Test Standard  |
|---------------------|-------|-------------------|----------------|
| Water absorption    | 9     | %                 | Sim. to ISO 62 |
| Humidity absorption | 3     | %                 | Sim. to ISO 62 |
| Density             | 1100  | kg/m <sup>3</sup> | 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                            | 55 - 90   | °C   | -             |
| Feed temperature                            | 60 - 80   | °C   | -             |
| Zone 1                                      | 230 - 240 | °C   | -             |
| Zone 2                                      | 230 - 240 | °C   | -             |
| Zone 3                                      | 230 - 270 | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

High impact or impact modified

**Regional Availability**

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