RAVAMID® B BK45

PA6 Ravago Group

Product Texts

Polyamide 6 Black containing recycled material, good mechanical properties, 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	**1.2**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**55**	MPa	ISO 527
Stress at break	**45**	MPa	ISO 527
Strain at break	**20**	%	ISO 527
Flexural modulus, 23°C	**2500**	MPa	ISO 178
Charpy impact strength, +23°C	**45**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**7.5**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**4.5**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**7**	kJ/m²	ISO 180/1A
Izod notched impact strength	**4.5**	kJ/m²	ISO 180/1A
Temperature	**-23**	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**220**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**65**	°C	ISO 75-1/-2
Vicat softening temperature, B	**205**	°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	**1140**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**75**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.12**	%	-
Melt temperature	**240 - 270**	°C	-
Mold temperature	**70 - 90**	°C	-
Zone 1	**220 - 230**	°C	-
Zone 2	**230 - 245**	°C	-
Zone 3	**250 - 260**	°C	-
Nozzle temperature	**250 - 260**	°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
U.V. stabilized or stable to weather, Heat stabilized or stable to heat