

RamLloy PNA780G4NT

(PPE+PA66)-GF20

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	14	g/10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	6850	MPa	ISO 527
Tensile Strength	140	MPa	ISO 527
Strain at break	3.15	%	ISO 527
Flexural modulus, 23°C	6250	MPa	ISO 178
Flexural strength	200	MPa	ISO 178
Charpy impact strength, +23°C	75	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	74	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	9	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10.5	kJ/m ²	ISO 180/1A
Izod notched impact strength	10	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	207	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	237	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
Vicat Temperature	246	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water absorption	3.2	%	Sim. to ISO 62
Humidity absorption	1	%	Sim. to ISO 62
Density	1250	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.07	%	-
Mold temperature	80 - 100	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 290	°C	-
Zone 3	280 - 300	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Natural Color

Special Characteristics

U.V. stabilized or stable to weather

Certifications

RoHS compliant

Regional Availability

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