

PlusTek PD119GN44

PA12

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	550	MPa	ISO 527
Tensile Strength	35	MPa	ISO 527
Yield strain	20	%	ISO 527
Flexural modulus, 23°C	900	MPa	ISO 178
Flexural strength	33	MPa	ISO 178
Izod notched impact strength, +23°C	37	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	1.5	%	Sim. to ISO 62
Humidity absorption	0.7	%	Sim. to ISO 62
Density	1020	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	60 - 80	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	210 - 230	°C	-
Zone 2	210 - 230	°C	-
Zone 3	220 - 250	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

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