

**PlusTek RD104BK11-T**

PA12

Polyram

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.8</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	<b>1310</b>	MPa	ISO 527
Tensile Strength	<b>43</b>	MPa	ISO 527
Yield strain	<b>10.5</b>	%	ISO 527
Flexural modulus, 23°C	<b>1300</b>	MPa	ISO 178
Flexural strength	<b>50</b>	MPa	ISO 178
Izod notched impact strength, +23°C	<b>8</b>	kJ/m <sup>2</sup>	ISO 180/1A
<b>Thermal properties</b>			
<b>ISO Data</b>			
Burning behav. at 1.5 mm nom. thickn. Thickness tested	<b>HB</b> <b>1.6</b>	class mm	IEC 60695-11-10 -
<b>Other properties</b>			
Water absorption	<b>1.5</b>	%	Sim. to ISO 62
Humidity absorption	<b>0.7</b>	%	Sim. to ISO 62
Density	<b>1010</b>	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.15</b>	%	-
Mold temperature	<b>70 - 90</b>	°C	-
Feed temperature	<b>60 - 70</b>	°C	-
Zone 1	<b>220 - 230</b>	°C	-
Zone 2	<b>220 - 230</b>	°C	-
Zone 3	<b>230 - 240</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

U.V. stabilized or stable to weather

**Delivery form**

Black

**Regional Availability**

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