

RamLloy PB917G4OR21

(PA6+PP)-GF20

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	6300	MPa	ISO 527
Tensile Strength	105	MPa	ISO 527
Strain at break	2.6	%	ISO 527
Izod notched impact strength, +23°C	8.5	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	5.5	%	Sim. to ISO 62
Humidity absorption	1.5	%	Sim. to ISO 62
Density	1200	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	65 - 80	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	240 - 280	°C	-
Zone 2	240 - 280	°C	-
Zone 3	240 - 280	°C	-

Characteristics**Processing**

Injection Molding

Certifications

RoHS compliant

Regional Availability

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