RAVAMID® R200 GF15 F

PA6-GF15 Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**25**	g/10min	ISO 1133
Temperature	**250**	°C	-
Load	**2.16**	kg	-
ASTM Data			
Mold Shrinkage, MD	**0.0075**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Stress at break	**80**	MPa	ISO 527
Strain at break	**5**	%	ISO 527
Flexural modulus, 23°C	**4100**	MPa	ISO 178
Flexural strength	**80**	MPa	ISO 178
Izod notched impact strength, +23°C	**5.5**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**230**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**150**[ann.]	°C	ISO 75-1/-2
Vicat softening temperature, B	**200**	°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	-

ann.: annealed

Other properties	Value	Unit	Test Standard
Density	**1220**	kg/m³	ISO 1183
Water Absorption, 24hr	**1.1**	%	ASTM D 570

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

Regional Availability

Europe