

**Polyramid ARV20 BK10**

PA66-GF20

Polyram

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	1.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.6 / *	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	6000 / 3500	MPa	ISO 527
Tensile Strength	125 / 75	MPa	ISO 527
Strain at break	3.5 / 5.5	%	ISO 527
Flexural modulus, 23°C	5000 / -	MPa	ISO 178
Flexural strength	165 / -	MPa	ISO 178
Charpy impact strength, +23°C	40 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	5 / 12	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	6 / -	kJ/m <sup>2</sup>	ISO 180/1A

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	200 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thicken.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Humidity absorption	2 / *	%	Sim. to ISO 62
Density	1280 / -	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	80 - 90	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	260 - 280	°C	-
Zone 2	260 - 280	°C	-
Zone 3	280 - 300	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

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