RAVAMID® R210 GF20

PA66-GF20 Ravago Group

Product Texts

Polyamide 6.6 compound 20% Glass filled for injection molding also available in custom colors, heat stabilized (H) and UV stabilized (UV).

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	**0.0097**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Stress at break	**130**	MPa	ISO 527
Strain at break	**3**	%	ISO 527
Flexural modulus, 23°C	**6000**	MPa	ISO 178
Charpy impact strength, +23°C	**50**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**8.5**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**8**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**265**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**225**	°C	ISO 75-1/-2
Vicat softening temperature, B	**235**	°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	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Surface resistivity	**1E15**	Ohm	IEC 62631-3-2
Electric strength	**18**	kV/mm	IEC 60243-1
Comparative tracking index	**600**	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	**1300**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**85**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.12**	%	-
Melt temperature	**270 - 290**	°C	-
Mold temperature	**70 - 90**	°C	-
Zone 1	**250 - 260**	°C	-
Zone 2	**260 - 270**	°C	-
Zone 3	**280 - 290**	°C	-
Nozzle temperature	**280 - 285**	°C	-
Screw speed	**50 - 80**	rpm	-
Back pressure	**0.4 - 0.8**	MPa	-
Holding pressure	**6 - 8**	MPa	-

Characteristics

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Processing
Injection Molding

Special Characteristics
U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Regional Availability
Europe

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