

**PlusTek RA325G5BK10**

PA66-GF25

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	8300	MPa	ISO 527
Tensile Strength	125	MPa	ISO 527
Strain at break	2.5	%	ISO 527
Izod notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
<b>Thermal properties</b>			
<b>ISO Data</b>			
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.6	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	3	mm	-
<b>Other properties</b>			
Water absorption	4	%	Sim. to ISO 62
Humidity absorption	1.2	%	Sim. to ISO 62
Density	1340	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.15	%	-
Mold temperature	70 - 120	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	250 - 270	°C	-
Zone 2	265 - 290	°C	-
Zone 3	265 - 290	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

Flame retardant, Halogen-free

**Certifications**

RoHS compliant

**Regional Availability**

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