

PlusTek RA321G6BK11

PA66-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	12600	MPa	ISO 527
Tensile Strength	150	MPa	ISO 527
Strain at break	1.8	%	ISO 527
Izod notched impact strength, +23°C	10	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
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	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	3	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	5.5	%	Sim. to ISO 62
Humidity absorption	1.7	%	Sim. to ISO 62
Density	1640	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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

Special Characteristics

Flame retardant

Delivery form

Black

Regional Availability

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