

PlusTek PA318G4BK38

PA66/6-GF20

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	7200	MPa	ISO 527
Tensile Strength	140	MPa	ISO 527
Strain at break	3.2	%	ISO 527
Izod notched impact strength, +23°C	6	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Humidity absorption	1.2	%	Sim. to ISO 62
Density	1290	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°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

Features

Copolymer

Delivery form

Black

Regional Availability

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

Special Characteristics

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