

RAVAMID® C GF35 BK IK

PA666-GF35

Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.0016	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0081	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	6500	MPa	ISO 527
Yield stress	110	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	7000	MPa	ISO 178
Izod notched impact strength, +23°C	6.5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	220^[ann.]	°C	ISO 75-1/-2
Vicat softening temperature, B	205	°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	-

ann.: annealed

Other properties	Value	Unit	Test Standard
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1410	kg/m ³	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	240 - 280	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	230 - 240	°C	-
Zone 2	250 - 260	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	260 - 265	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-
Holding pressure	6 - 8	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Black

Features

Copolymer

Certifications

Recycled Resin Content

Regional Availability

Europe