

PlusTek PDC100NT

PA*

Polyram

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

| Mechanical properties | Value | Unit | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| ISO Data | | | |
| Tensile Modulus | 1600 | MPa | ISO 527 |
| Tensile Strength | 60 | MPa | ISO 527 |
| Yield strain | 9 | % | ISO 527 |
| Strain at break | 100 | % | ISO 527 |
| Flexural modulus, 23°C | 1560 | MPa | ISO 178 |
| Flexural strength | 80 | MPa | ISO 178 |
| Charpy notched impact strength, +23°C | 10 | kJ/m ² | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 3 | kJ/m ² | ISO 179/1eA |

| Thermal properties | Value | Unit | Test Standard |
|--|-------|------|---------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 103 | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 124 | °C | ISO 75-1/-2 |

| Other properties | Value | Unit | Test Standard |
|------------------|-------|-------------------|---------------|
| Density | 1010 | kg/m ³ | ISO 1183 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature | 80 - 100 | °C | - |
| Pre-drying - Time | 4 - 6 | h | - |
| Processing humidity | ≤0.08 | % | - |
| Mold temperature | 80 - 90 | °C | - |
| Feed temperature | 40 - 45 | °C | - |
| Zone 1 | 250 - 260 | °C | - |
| Zone 2 | 260 - 270 | °C | - |
| Zone 3 | 260 - 270 | °C | - |

Characteristics**Processing**

Injection Molding

Chemical Resistance

General Chemical Resistance

Special Characteristics

Transparent

Regional Availability

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