

**PlusTek PB845NT**

PA6

Polyram

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	1.0 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2300 / 1040	MPa	ISO 527
Tensile Strength	55 / 31	MPa	ISO 527
Yield strain	4.5 / -	%	ISO 527
Strain at break	- / 66	%	ISO 527
Flexural modulus, 23°C	1950 / -	MPa	ISO 178
Flexural strength	84 / -	MPa	ISO 178
Charpy impact strength, +23°C	N / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	N / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	56 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	15 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	50 / 80	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	50 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	112 / *	°C	ISO 75-1/-2
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	3.0 / *	mm	-

Other properties	dry / cond	Unit	Test Standard
Water absorption	9 / *	%	Sim. to ISO 62
Humidity absorption	3 / *	%	Sim. to ISO 62
Density	1090 / -	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.15	%	-
Mold temperature	55 - 90	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	230 - 240	°C	-
Zone 2	230 - 240	°C	-
Zone 3	230 - 270	°C	-

**Characteristics****Processing**

Injection Molding

**Certifications**

RoHS compliant

**Delivery form**

Natural Color

**Regional Availability**

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

**Special Characteristics**

High impact or impact modified