

**PlusTek PB845SI1**

PA6

Polyram

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

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2410	MPa	ISO 527
Tensile Strength	56	MPa	ISO 527
Strain at break	10	%	ISO 527
Izod notched impact strength, +23°C	22	kJ/m <sup>2</sup>	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	9	%	Sim. to ISO 62
Humidity absorption	3	%	Sim. to ISO 62
Density	1100	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

**Special Characteristics**

High impact or impact modified

**Regional Availability**

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