RAVAMID® B BK45 SM

PA6 Ravago Group

Product Texts
Polyamide 6 black containing recycled material, self lubricating grade, also available Heat Stabilized (H) and UV Stabilized (UV).

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**1.1**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.2**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**50**	MPa	ISO 527
Stress at break	**40**	MPa	ISO 527
Strain at break	**15**	%	ISO 527
Flexural modulus, 23°C	**2200**	MPa	ISO 178
Charpy notched impact strength, +23°C	**6.5**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**7**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**220**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**60**	°C	ISO 75-1/-2
Vicat softening temperature, B	**200**	°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	-

Other properties	Value	Unit	Test Standard
Humidity absorption	**0.25**	%	Sim. to ISO 62
Density	**1140**	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**75**	°C	-
Pre-drying - Time	**3 - 4**	h	-
Processing humidity	**≤0.12**	%	-
Melt temperature	**240 - 270**	°C	-
Mold temperature	**70 - 90**	°C	-
Zone 1	**220 - 230**	°C	-
Zone 2	**230 - 245**	°C	-
Zone 3	**250 - 260**	°C	-
Nozzle temperature	**250 - 260**	°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

Additives
Lubricants

Features
Tribologic Grade

Certifications
Recycled Resin Content

Regional Availability
Europe

Special Characteristics

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