

Edgetek™ PA-50GF/000 BK004

Polyamide 66 + PA 6I/6T

PolyOne Corporation

Message:

Glass Fiber Reinforced PPA Compound.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.63	g/cm ³	ISO 1183
Molding Shrinkage	0.20 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	230	MPa	ISO 527-2
Flexural Modulus	16800	MPa	ISO 178
Flexural Strength	320	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	285	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 120	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	320 - 340	°C	
Middle Temperature	320 - 340	°C	
Front Temperature	320 - 340	°C	
Mold Temperature	120 - 135	°C	
Injection instructions			

Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW

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