

Edgetek™ PA-45GF/000 BK005

Polyamide

PolyOne Corporation

Message:

Edgetek™PA-45GF/000 BK005 is a polyamide product containing a 45% glass fiber reinforced material. It can be processed by injection molding and is available in the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 45% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	160	MPa	ASTM D638
Flexural Modulus ²	11000	MPa	ASTM D790
Flexural Strength ³	300	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	140	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	280	°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		UL 94
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			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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