

Nylon 6, 30% Glass Bead Reinforced, Black Compound.

PLUSTEK PB340S6 BK offers good dimensional stability in injection moulding applications.

General Properties

Polymer Type	PA6
Filler / Reinforcement	Glass Bead Reinforced
Processing Method	Injection Moulding
Form	Uniform Granules

Physical Properties	Test Method	Unit	D-A-M
Density	ISO 1183	g/cm ³	1.35
Water absorption (equilibrium humidity @ 50 RH)	ISO 62	%	2
Water absorption (equilibrium @ 23 deg C)	ISO 62	%	6.5
Mould shrinkage (in flow @ 2mm)	INTERNAL	%	0.9 - 1.1
Mould shrinkage (X flow @ 2mm)	INTERNAL	%	0.95 - 1.1

Mechanical Properties	Test Method	Unit	D-A-M	Conditioned
Tensile Modulus	ISO 527-2	MPa	4250	
Tensile Stress @ Break	ISO 527-2	MPa	65	
Tensile Strain @ Break	ISO 527-2	%	4.6	
Flexural Modulus	ISO 178	MPa	4100	
Flexural Strength	ISO 178	MPa	110	
Charpy Notched Impact	ISO 179/1-eA	kJ/m ²	4	

Thermal Properties	Test Method	Unit	D-A-M
Heat Distortion Temperature @ 0.45MPa	ISO75-2	°C	180
Heat Distortion Temperature @ 1.8MPa	ISO75-2	°C	85

Flammability Properties	Test Method	Unit	D-A-M
Flame Rating	Internal test (UL94)	*	HB (1.5mm)

Electrical Properties	Test Method	Unit	D-A-M	Conditioned
Surface Resistivity	IEC 60093	ohms		1.00E+13
Volume Resistivity	IEC 60093	ohms.cm	1.00E+15	1.00E+12
Electric Strength (3mm)	IEC 60243-1	kV/mm	11	8
Comparative Tracking Index	IEC 60112	V	500	

Recommended Processing	Unit	
Drying Temperature	°C	80
Drying Time	Hours	2 - 4
Processing Temperatures (Barrel)	°C	240 - 280
Melt temperature range	°C	240 - 290
Mould Temperature	°C	65 - 80

The material is supplied predried. Additional drying will be necessary if the material is open to the air for more than 2 to 3 hours. Redrying is also recommended after prolonged storage in undisturbed original packaging. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present. Excessive drying temperature or duration will lead to progressive yellowing of natural or light colours.

Packaging and Storage

25Kg Moisture proof Aluminium sacks (Standard packaging). May be supplied in Octabins, Big bags, Bulk Silo etc, on request.
Store in dry, well ventilated areas away from heat sources.

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All data provided is based on typically achieved values and not to be taken as specifications.
Values will differ with addition of additives, pigments or other materials. Polyram UK Ltd gives no guarantee or warranty in connection with this data and it is to be used at individuals own discretion and risk.

