

PLUSTEK PD305G6

Polyamide 12
Polyram Ram-On Industries

Message:
30% GLASS FIBER REINFORCED POLYAMIDE 12 FOR INJECTION MOLDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.35	g/cm ³	ASTM D792
--	1.34	g/cm ³	ISO 1183
Molding Shrinkage			
Flow	0.070 - 0.50	%	
--	0.070 - 0.50	%	ISO 2577
Water Absorption			
Saturation	1.2	%	ASTM D570
Saturated, 23°C	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	130	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	5.0	%	ASTM D638, ISO 527-2
Flexural Modulus	6000	MPa	ASTM D790, ISO 178
Flexural Strength	180	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	170	J/m	ASTM D256
23°C	16	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Maximum operating temperature-Short Peaks Operation	145	°C	
Maximum Continuous Use Temperature	100	°C	
Melting Temperature	165 - 175	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value		Test Method
Flame Rating (3.00 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	3.0	hr	

Suggested Max Moisture	0.10	%
Rear Temperature	215 - 255	°C
Middle Temperature	220 - 260	°C
Front Temperature	225 - 265	°C
Mold Temperature	65.0 - 105	°C
Injection Pressure	70.0 - 105	MPa
Injection Rate	Fast	
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.350 - 0.700	MPa
Screw Speed	60 - 90	rpm

Injection instructions

Fill Speed: 50 to 75 mm/sec

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