

PLUSTEK PB200

Polyamide 6
Polyram Ram-On Industries

Message:
Polyamide 6 high viscosity , formulated for extrusion applications.

General Information			
Features	Viscosity, High		
RoHS Compliance	RoHS compliance		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.3 - 1.7	%	ASTM D955
--	1.3 - 1.7	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2600	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	65.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			
Fracture	45	%	ASTM D638
Fracture	65	%	ISO 527-2
Flexural Modulus	2100	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	80	J/m	ASTM D256
23°C	8.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	220	°C	ISO 11357-3, ASTM D3418
Injection	Nominal Value	Unit	Test Method
Drying Temperature	85.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	220 - 260	°C	
Middle Temperature	230 - 265	°C	
Front Temperature	250 - 270	°C	
Mold Temperature	55.0 - 95.0	°C	
Injection Pressure	70.0 - 105	MPa	
Injection Rate	Fast		
Holding Pressure	30.0 - 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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