

PLUSTEK RB133

Polyamide 6
Polyram Ram-On Industries

Message:
INDUSTRIAL GRADE GENERAL PURPOSE POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS. RB703 IS A UV STABILIZED GRADE.

General Information			
Features	General		
Uses	Industrial application		
	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.4 - 1.8	%	ASTM D955
--	1.4 - 1.8	%	ISO 2577
Water Absorption (Equilibrium, 23°C, 50% RH)	1.3	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	> 70.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 15	%	ASTM D638, ISO 527-2
Flexural Modulus	> 2200	MPa	ASTM D790, ISO 178
Flexural Strength	> 95.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	> 60	J/m	ASTM D256
23°C	> 7.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	> 160	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	> 65.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Flammability	10	mm/min	FMVSS 302
Injection	Nominal Value	Unit	
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

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

