

PLUSTEK PA350M4

Polyamide 66

Polyram Ram-On Industries

Message:

20% Mineral Reinforced Polyamide 6.6 for Injection Moulding applications.

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.90 - 1.3	%	ASTM D955
--	0.90 - 1.3	%	ISO 2577
Water Absorption			
Saturation	6.6	%	ASTM D570
Saturated, 23°C	6.6	%	ISO 62
Equilibrium, 23°C, 50% RH	2.2	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	119		ASTM D785
R scale	119		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5500	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	80.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0 - 4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	4600	MPa	ASTM D790, ISO 178
Flexural Strength	150	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	65	J/m	ASTM D256
23°C	5.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	240	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	210	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	200	°C	
Maximum Continuous Use Temperature	80	°C	
Melting Temperature	256	°C	ISO 11357-3, ASTM D3418

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	85	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.70		IEC 60250
Flammability	Nominal Value	Unit	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	0.15	%	
Rear Temperature	270 - 280	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	285 - 310	°C	
Mold Temperature	65.0 - 110	°C	
Injection Pressure	70.0 - 125	MPa	
Injection Rate	Fast		
Holding Pressure	35.0 - 85.0	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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