

PLUSTEK RD120

Polyamide 12
Polyram Ram-On Industries

Message:
POLYAMIDE 12 FOR EXTRUSION APPLICATIONS.

General Information			
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.46 to 1.2	%	ISO 2577
--	0.46 to 1.2	%	
Water Absorption			
Saturation	1.5	%	ASTM D570
Saturation, 23°C	1.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	34.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	300	%	ASTM D638, ISO 527-2
Flexural Modulus	400	MPa	ASTM D790, ISO 178
Flexural Strength	20.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	No Break		ASTM D256, ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	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 to 255	°C	
Middle Temperature	220 to 260	°C	
Front Temperature	225 to 265	°C	
Mold Temperature	65.0 to 105	°C	
Injection Pressure	70.0 to 105	MPa	
Injection Rate	Fast		
Holding Pressure	35.0 to 70.0	MPa	

Back Pressure	0.350 to 0.700	MPa
Screw Speed	60 to 90	rpm

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