PLUSTEK PA507

Polyamide 66

Polyram Ram-On Industries

Message:

FLAME RETARDANT POLYAMIDE 6.6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.15	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.0 - 1.4	%	ASTM D955
--	1.0 - 1.4	%	ISO 2577
Water Absorption			
Saturation	7.5	%	ASTM D570
Saturated, 23°C	7.5	%	ISO 62
Equilibrium, 23°C, 50% RH	2.5	%	ASTM D570, ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	80.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	15	%	ASTM D638, ISO 527-2
Flexural Modulus	3000	MPa	ASTM D790, ISO 178
Flexural Strength	120	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	30	J/m	ASTM D256
23°C	30	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	95.0	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	220	°C	ASTM D648, ISO 75-2/A
Maximum Service Temperature			
-- [1]	> 180	°C	
--	100	°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	70	kV/mm	IEC 60243-1

Dielectric Constant (1 MHz)	3.30		IEC 60250
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (3.00 mm)	V-0		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			
NOTE			
1.	Short Peaks Operation		

Recommended distributors for this material

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