

PLUSTEK PB350M8

Polyamide 6

Polyram Ram-On Industries

Message:

20% Mineral Filled Polyamide 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	1.38	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.80 - 1.1	%	ASTM D955
--	0.80 - 1.1	%	ISO 2577
Water Absorption			
Saturation	7.0	%	ASTM D570
Saturated, 23°C	7.0	%	ISO 62
Equilibrium, 23°C, 50% RH	2.5	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	110		ASTM D785
R scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	85.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 4.0	%	ASTM D638, ISO 527-2
Flexural Modulus			
--	5200	MPa	ASTM D790
--	6300	MPa	ISO 178
Flexural Strength	110	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	50	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	200	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	140	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	180	°C	

Maximum Continuous Use Temperature	70	°C	
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	100	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.50		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	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

