

PLUSTEK PB901

Polyamide 6
Polyram Ram-On Industries

Message:
POLYAMIDE 6 FOR VERY THIN ELECTRICAL EXTRUDED CABLE COATING.

General Information			
Uses	Wire and cable applications		
Processing Method	Extrusion coating		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.2 - 1.6	%	ASTM D955
--	1.2 - 1.6	%	ISO 2577
Water Absorption			
Saturation	5.5	%	ASTM D570
Saturated, 23°C	5.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	85.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	100	%	ASTM D638, ISO 527-2
Flexural Modulus	2500	MPa	ASTM D790, ISO 178
Flexural Strength	110	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	30	J/m	ASTM D256
23°C	3.0	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	55.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	150	°C	
Maximum Continuous Use Temperature	80	°C	
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+14	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)	V-2	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

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