

PLUSTEK PD300G5

Polyamide 12

Polyram Ram-On Industries

Message:

25% GLASS-FIBER REINFORCED POLYAMIDE 12,HEAT STABILIZED AND HYDROLYSIS RESISTANCE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Additive	Hydrolysis resistance heat stabilizer		
Features	Hydrolysis resistance Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Water Absorption			
Saturation	1.4	%	ASTM D570
Saturated, 23°C	1.4	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	100	MPa	ASTM D638, ISO 527-2
Tensile Elongation			
Fracture	3.5	%	ASTM D638
Fracture	3.0	%	ISO 527-2
Flexural Modulus	5000	MPa	ASTM D790, ISO 178
Flexural Strength	150	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	90	J/m	ASTM D256
23°C	10	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	177	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	163	°C	ASTM D648, ISO 75-2/A
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 - 255	°C
Middle Temperature	220 - 260	°C
Front Temperature	225 - 265	°C
Mold Temperature	65.0 - 105	°C
Injection Pressure	70.0 - 105	MPa
Injection Rate	Fast	
Holding Pressure	35.0 - 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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