

PLUSTEK PB315G33

Polyamide 6
Polyram Ram-On Industries

Message:
33% GLASS FIBER REINFORCED, HEAT AND UV STABILIZED POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Additive	heat stabilizer		
	UV stabilizer		
Features	Good UV resistance		
	Thermal Stability		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.20 - 0.50	%	ISO 2577
--	0.20 - 0.50	%	
Water Absorption			
Saturation	6.6	%	ASTM D570
Saturated, 23°C	6.6	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	113		ASTM D785
R scale	113		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	180	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.5	%	ASTM D638, ISO 527-2
Flexural Modulus	8500	MPa	ASTM D790, ISO 178
Flexural Strength	230	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	170	J/m	ASTM D256
23°C	17	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, not annealed	217	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	205	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	200	°C	
Maximum Continuous Use Temperature	110	°C	
Melting Temperature	218	°C	ISO 11357-3, ASTM D3417
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	80	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.80		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			

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