

PLUSTEK PD502G6

Polyamide 12
Polyram Ram-On Industries

Message:
30% GLASS FIBER REINFORCED, V-0 1.6mm, POLYAMIDE 12 FOR INJECTION MOLDING APPLICATION.

General Information			
UL YellowCard	E174094-521021		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.67	g/cm ³	ASTM D792, ISO 1183
Water Absorption			
Saturation	1.2	%	ASTM D570
Saturated, 23°C	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7600	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	115	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	6.0	%	ASTM D638, ISO 527-2
Flexural Modulus	7100	MPa	ASTM D790, ISO 178
Flexural Strength	185	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/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	165 - 175	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm)	V-0	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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Recommended distributors for this material

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