

PLUSTEK PA865G6

Polyamide 66
Polyram Ram-On Industries

Message:
30% GLASS FIBER REINFORCED, IMPACT MODIFIED POLYAMIDE 6.6 FOR INJECTION MOULDING APPILCATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.30 - 0.70	%	ASTM D955
--	0.30 - 0.70	%	ISO 2577
Water Absorption			
Saturation	4.5	%	ASTM D570
Saturated, 23°C	4.5	%	ISO 62
Equilibrium, 23°C, 50% RH	1.4	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	121		ASTM D785
R scale	121		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	125	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	5500	MPa	ASTM D790, ISO 178
Flexural Strength	170	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	250	J/m	ASTM D256
23°C	25	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	250	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	240	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	> 200	°C	
Maximum Continuous Use Temperature	110	°C	

Melting Temperature	256	°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	90	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.70		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	270 - 280	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	285 - 310	°C	
Mold Temperature	65.0 - 110	°C	
Injection Pressure	70.0 - 125	MPa	
Injection Rate	Fast		
Holding Pressure	35.0 - 85.0	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

