PLUSTEK PB145

Polyamide 6

Polyram Ram-On Industries

Message:

General puprpose Polyamide 6 for Fast Cycle Injection Moulding applications.

General Information			
Features	Fast molding cycle General		
Uses	General		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.14	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.3 - 1.7	%	ASTM D955
--	1.3 - 1.7	%	ISO 2577
Water Absorption			
Saturation	9.5	%	ASTM D570
Saturated, 23°C	9.5	%	ISO 62
Equilibrium, 23°C, 50% RH	3.0	%	ASTM D570, ISO 62
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			
Class r	120		ASTM D785
R scale	120		ISO 2039-2
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	90.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 10	%	ASTM D638, ISO 527-2
Flexural Modulus	2600	MPa	ASTM D790, ISO 178
Flexural Strength	100	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179
-30°C	3.5	kJ/m²	ISO 179
23°C	5.5	kJ/m²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		ISO 179
23°C	No Break		ISO 179
Notched Izod Impact			
-30°C	35	J/m	ASTM D256

23°C	50	J/m	ASTM D256
-30°C	3.5	kJ/m²	ISO 180
23°C	5.0	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	185	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	80.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	180	°C	
Maximum Continuous Use Temperature	80	°C	
Flammability	17	mm/min	FMVSS 302
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+17	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			UL 94
1.60 mm	V-2		UL 94
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

Recommended distributors for this material

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