

PLUSTEK PB840

Polyamide 6

Polyram Ram-On Industries

Message:

IMPACT MODIFIED POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06 - 1.10	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.2 - 1.6	%	
--	1.2 - 1.6	%	ISO 2577
Water Absorption			
Saturation	8.0	%	ASTM D570
Saturated, 23°C	8.0	%	ISO 62
Equilibrium, 23°C, 50% RH	2.5	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	114		ASTM D785
R scale	114		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 50	%	ASTM D638, ISO 527-2
Flexural Modulus	2200	MPa	ASTM D790, ISO 178
Flexural Strength	85.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	43	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	500	J/m	ASTM D256
23°C	40	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	170	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	65.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	180	°C	

Maximum Continuous Use Temperature	80	°C	
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 (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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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

