

PLUSTEK RA304G6

Polyamide 66
Polyram Ram-On Industries

Message:
30% GLASS FIBER REINFORCED, HEAT STABILIZED AND HYDROLYSIS RESISTANT POLYAMIDE 66 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
	Hydrolysis Resistant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33 to 1.39	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.30 to 0.40	%	
--	0.30 to 0.40	%	ISO 2577
Water Absorption			
Saturation	5.6	%	ASTM D570
Saturation, 23°C	5.6	%	ISO 62
Equilibrium, 23°C, 50% RH	1.7	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	170	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	7800	MPa	ASTM D790, ISO 178
Flexural Strength	280	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C	10	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	260	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	250	°C	ASTM D648, ISO 75-2/A
Melting Temperature	256	°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
Electric 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 to 280	°C	
Middle Temperature	280 to 300	°C	
Front Temperature	285 to 310	°C	
Mold Temperature	65.0 to 110	°C	
Injection Pressure	70.0 to 125	MPa	
Injection Rate	Fast		
Holding Pressure	35.0 to 85.0	MPa	
Back Pressure	0.350 to 0.700	MPa	
Screw Speed	60 to 90	rpm	

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