

PLUSTEK RB306G6

Polyamide 6
Polyram Ram-On Industries

Message:
30% GLASS-FIBER REINFORCED, HEAT STABILIZED POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.35	%	ASTM D955
Water Absorption			ASTM D570
Saturation	6.6	%	ASTM D570
Equilibrium, 23°C, 50% RH	2.1	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	140	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	7000	MPa	ASTM D790
Flexural Strength	200	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	217	°C	ASTM D648
1.8 MPa, not annealed	205	°C	ASTM D648
Maximum operating temperature-Short Peaks Operation	200	°C	
Maximum Continuous Use Temperature	110	°C	
Peak Melting Temperature	218	°C	ASTM D3418
Flammability	Nominal Value		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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