

PLUSTEK RD101

Polyamide 12
Polyram Ram-On Industries

Message:
UNFILLED FLEXIBLE POLYAMIDE 12 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.5	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	30.0	MPa	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	450	MPa	ASTM D790
Flexural Strength	25.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	500	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	125	°C	ASTM D648
1.8 MPa, not annealed	55.0	°C	ASTM D648
Peak Melting Temperature	165 - 175	°C	ASTM D3417
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+10	ohms · cm	IEC 60093
Dielectric Strength	55	kV/mm	IEC 60243-1
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	0.10	%	
Rear Temperature	215 - 255	°C	
Middle Temperature	220 - 260	°C	
Front Temperature	225 - 265	°C	

Mold Temperature	65.0 - 105	°C
Injection Pressure	70.0 - 105	MPa
Injection Rate	Fast	
Holding Pressure	35.0 - 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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