

PLUSTEK PD120BK11

Polyamide 12
Polyram Ram-On Industries

Message:
POLYAMIDE 12 UV STABILIZED FOR EXTRUSION APPLICATIONS.

General Information			
Additive	UV stabilizer		
RoHS Compliance	RoHS compliance		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.02	g/cm ³	ASTM D792
--	1.03	g/cm ³	ISO 1183
Water Absorption			
Saturation	1.5	%	ASTM D570
Saturated, 23°C	1.1	%	ISO 62
Balance	0.70	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.70	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	40.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	400	%	ASTM D638, ISO 527-2
Flexural Modulus	350	MPa	ASTM D790, ISO 178
Flexural Strength	30.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C	No Break		ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	175	°C	ISO 11357-3
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	0.10	%	
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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