

PLUSTEK PA325G5

Polyamide 66
Polyram Ram-On Industries

Message:
25% Glass Fiber Reinforced, Flame Retardant, Halogen Free Polyamide 6.6 for Injection Moulding applications.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Additive	Flame retardancy		
Features	Halogen-free		
	Flame retardancy		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.30 - 0.70	%	ISO 2577
--	0.30 - 0.70	%	
Water Absorption			
Saturation	6.0	%	ASTM D570
Saturated, 23°C	6.0	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	120		ASTM D785
R scale	120		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	140	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	8000	MPa	ASTM D790, ISO 178
Flexural Strength	200	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	70	J/m	ASTM D256
23°C	7.0	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	250	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	240	°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+12	ohms	IEC 60093
Volume Resistivity	1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	80	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.70		IEC 60250
Comparative Tracking Index	550	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
	V-0		

Flame Rating (3.00 mm)	5VA		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	825	°C	IEC 60695-2-13

Injection	Nominal Value	Unit
Drying Temperature	85.0	°C
Drying Time	3.0	hr
Suggested Max Moisture	0.15	%
Rear Temperature	270 - 280	°C
Middle Temperature	280 - 300	°C
Front Temperature	285 - 310	°C
Mold Temperature	65.0 - 110	°C
Injection Pressure	70.0 - 125	MPa
Injection Rate	Fast	
Holding Pressure	35.0 - 85.0	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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