

PLUSTEK RB145

Polyamide 6
Polyram Ram-On Industries

Message:
INDUSTRIAL GRADE GENERAL PURPOSE POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	General		
Uses	Industrial application		
	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792, ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2470	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	75.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	85	%	ASTM D638, ISO 527-2
Flexural Modulus	2000	MPa	ASTM D790, ISO 178
Flexural Strength	90.0	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/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
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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