

PLUSTEK PB340S4

Polyamide 6
Polyram Ram-On Industries

Message:
20% GLASS-BEADS REINFORCED, POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass Bead,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.80 to 1.2	%	ASTM D955
--	0.80 to 1.2	%	ISO 2577
Water Absorption			
Saturation	5.8	%	ASTM D570
Saturation, 23°C	5.8	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3700	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.1	%	ASTM D638, ISO 527-2
Flexural Modulus	3500	MPa	ASTM D790, ISO 178
Flexural Strength	100	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179
-30°C	25	kJ/m ²	
23°C	30	kJ/m ²	
Notched Izod Impact			
23°C	30	J/m	ASTM D256
23°C	3.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	190	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	90.0	°C	ASTM D648, ISO 75-2/A
Maximum Use Temperature - Short Peaks Operation	180	°C	
Maximum Continuous Use Temperature	80	°C	
Melting Temperature	218	°C	ISO 11357-3, ASTM D3417

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Electric Strength	80	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.80		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Glow Wire Flammability Index	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	220 to 260	°C	
Middle Temperature	230 to 265	°C	
Front Temperature	250 to 270	°C	
Mold Temperature	55.0 to 95.0	°C	
Injection Pressure	70.0 to 105	MPa	
Injection Rate	Fast		
Holding Pressure	30.0 to 70.0	MPa	
Back Pressure	0.350 to 0.700	MPa	
Screw Speed	60 to 90	rpm	

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