

PLUSTEK PB321I6

Polyamide 6

Polyram Ram-On Industries

Message:

30% Glass Fiber and Mineral Reinforced Polyamide 6 for Injection Moulding applications.

General Information			
Filler / Reinforcement	Glass \mineral, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.30 - 0.50	%	ASTM D955
--	0.30 - 0.50	%	ISO 2577
Water Absorption			
Saturation	6.6	%	ASTM D570
Saturated, 23°C	6.6	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	122		ASTM D785
R scale	122		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	110	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.5	%	ASTM D638, ISO 527-2
Flexural Modulus	7000	MPa	ASTM D790, ISO 178
Flexural Strength	200	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C	4.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Maximum operating temperature-Short Peaks Operation	200	°C	
Maximum Continuous Use Temperature	110	°C	
Melting Temperature	218	°C	ISO 11357-3, ASTM D3417
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)	3.80		IEC 60250
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	0.15	%	
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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

