

PLUSTEK RB841

Polyamide 6

Polyram Ram-On Industries

Message:

IMPACT MODIFIED POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06 - 1.11	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.2 - 1.6	%	
--	1.2 - 1.6	%	ISO 2577
Water Absorption			
Saturation	8.0	%	ASTM D570
Saturated, 23°C	8.0	%	ISO 62
Equilibrium, 23°C, 50% RH	2.5	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1700	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	> 55.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			
Fracture	> 25	%	ASTM D638
Fracture	> 50	%	ISO 527-2
Flexural Modulus	> 1650	MPa	ASTM D790, ISO 178
Flexural Strength	> 70.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	> 150	J/m	ASTM D256
23°C	> 15	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	> 160	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	> 60.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
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	0.15	%
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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