

PLUSTEK RB301G6

Polyamide 6
Polyram Ram-On Industries

Message:
INDUSTRIAL GRADE 30% GLASS-FIBER REINFORCED POLYAMIDE 6 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Uses	Industrial application		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.20 - 0.30	%	ASTM D955
--	0.20 - 0.30	%	ISO 2577
Water Absorption (Equilibrium, 23°C, 50% RH)	0.90	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	> 130	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 2.0	%	ASTM D638, ISO 527-2
Flexural Modulus	> 6500	MPa	ASTM D790, ISO 178
Flexural Strength	> 200	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	> 80	J/m	ASTM D256
23°C	> 8.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	> 210	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	> 190	°C	ASTM D648, ISO 75-2/A
Melting Temperature	218	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
FMVSS Flammability	15	mm/min	FMVSS 302
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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