

PLUSTEK PD300G4

Polyamide 12
Polyram Ram-On Industries

Message:
20% GLASS-FIBER REINFORCED POLYAMIDE 12 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792, ISO 1183
Water Absorption			
Saturation	1.5	%	ASTM D570
Saturated, 23°C	1.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	90.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.5	%	ASTM D638, ISO 527-2
Flexural Modulus	4000	MPa	ASTM D790, ISO 178
Flexural Strength	140	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	90	J/m	ASTM D256
23°C	9.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	177	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	163	°C	ASTM D648, ISO 75-2/A
Melting Temperature	175	°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	0.10	%	
Rear Temperature	215 - 255	°C	
Middle Temperature	220 - 260	°C	
Front Temperature	225 - 265	°C	
Mold Temperature	65.0 - 105	°C	

Injection Pressure	70.0 - 105	MPa
Injection Rate	Fast	
Holding Pressure	35.0 - 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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Recommended distributors for this material

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

