

PLUSTEK PB350M6

Polyamide 6
Polyram Ram-On Industries

Message:

PLUSTEK PB350M6 is a polyamide 6 (nylon 6) material, which contains a 30% mineral filler. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is injection molding.

The main features of the PLUSTEK PB350M6 are:

- flame retardant/rated flame
- anti-warping
- Good dimensional stability

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Features	Good dimensional stability		
	Low warpage		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.80 - 1.1	%	ASTM D955
Water Absorption			ISO 62
23°C, 24 hr	6.2	%	ISO 62
Equilibrium, 23°C, 50% RH	2.2	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	85.0	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	5000	MPa	ASTM D790
Flexural Strength (Yield)	70.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	50	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	200	°C	ISO 75-2/B
1.8 MPa, not annealed	140	°C	ISO 75-2/A
Continuous Use Temperature	70.0	°C	ASTM D794
Melting Temperature (DSC)	218	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093

Dielectric Strength	100	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.50		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94

Additional Information

The value listed as Density, ISO 1183, was tested in accordance with DIN 53479. The value listed as Water absorption, ISO 62, was tested in accordance with DIN 53495. The value listed as HDT A (1.8 Mpa), ISO 75A, was tested in accordance with DIN 53461. The value listed as HDT B (0.45 Mpa), ISO 75B, was tested in accordance with DIN 53461. The value listed as Surface Resistivity, IEC 60093, was tested in accordance with DIN 53482. The value listed as Volume Resistivity, IEC 60093, was tested in accordance with DIN 53482. The value listed as Dielectric Strength, ASTM D149, was tested in accordance with VDE 0303/4. The value listed as Moisture Absorption 23°C/50%RH, ISO 62, was tested in accordance with DIN 53714. Max Temp. Short Peaks Operation: 180 °C

Injection	Nominal Value	Unit
Drying Temperature	85.0	°C
Drying Time	3.0	hr
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
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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