

PLUSTEK PA352M6

Polyamide 66
Polyram Ram-On Industries

Message:
30% Low Friction Mineral Filled, Polyamide 6.6 lubricated with Molybdenum for Injection Moulding applications.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Additive	Molybdenum disulfide lubricant		
Features	Low friction coefficient		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.80 - 1.2	%	ASTM D955
--	0.80 - 1.2	%	ISO 2577
Water Absorption			
Saturation	5.5	%	ASTM D570
Saturated, 23°C	5.5	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	%	ASTM D570, ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	120		ASTM D785
R scale	120		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	95.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	5000	MPa	ASTM D790, ISO 178
Flexural Strength	150	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C	4.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	235	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	145	°C	ASTM D648, ISO 75-2/A

Maximum operating temperature-Short Peaks Operation	220	°C	
Maximum Continuous Use Temperature	80	°C	
Melting Temperature	256	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	85	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.70		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	270 - 280	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	285 - 310	°C	
Mold Temperature	65.0 - 110	°C	
Injection Pressure	70.0 - 125	MPa	
Injection Rate	Fast		
Holding Pressure	35.0 - 85.0	MPa	
Back Pressure	0.350 - 0.700	MPa	
Screw Speed	60 - 90	rpm	
Injection instructions			

Fill Speed: 50 to 75 mm/sec

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

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

