PLUSTEK RA601

Polyamide 66

Polyram Ram-On Industries

Message:

HEAT RESISTANCE POLYAMIDE 66 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	Heat resistance, high		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.14	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.4 - 1.8	%	ASTM D955
--	1.4 - 1.8	%	ISO 2577
Water Absorption			
Saturation	8.5	%	ASTM D570
Saturated, 23°C	8.5	%	ISO 62
Equilibrium, 23°C, 50% RH	2.8	%	ASTM D570, ISO 62
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			
Class r	118		ASTM D785
R scale	118		ISO 2039-2
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	85.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	10	%	ASTM D638, ISO 527-2
Flexural Modulus	2700	MPa	ASTM D790, ISO 178
Flexural Strength	120	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	55	J/m	ASTM D256
23°C	5.5	kJ/m²	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	100	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	200	°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	120	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.60		IEC 60250
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (3.00 mm)	V-2		UL 94
Glow Wire Flammability Index	850	°C	IEC 60695-2-12
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

Recommended distributors for this material

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