

PLUSTEK PA100/PA100NT-N

Polyamide 66

Polyram Ram-On Industries

Message:

GENERAL PURPOSE POLYAMIDE 6.6 GRADE FOR INJECTION MOULDING APPLICATIONS.

General Information			
UL YellowCard	E174094-102347783		
Features	General		
Uses	General		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.4 - 1.8	%	ASTM D955
--	1.4 - 1.8	%	ISO 2577
Water Absorption			
Saturation	7.3	%	ASTM D570
Saturated, 23°C	7.3	%	ISO 62
Equilibrium, 23°C, 50% RH	4.4	%	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 Modulus	2700	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	85.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 10	%	ASTM D638, ISO 527-2
Flexural Modulus	2740	MPa	ASTM D790, ISO 178
Flexural Strength	120	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	2.5	kJ/m ²	ISO 179
23°C	3.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		ISO 179
23°C	No Break		ISO 179
Notched Izod Impact			
23°C	55	J/m	ASTM D256

-30°C	5.0	kJ/m ²	ISO 180
23°C	6.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	205	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	75.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	150	°C	
Maximum Continuous Use Temperature	80	°C	
Flammability	12	mm/min	FMVSS 302
Melting Temperature	264	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	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 (1.60 mm)	V-2		UL 94
Glow Wire Flammability Index	750	°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			

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