

PLUSTEK PB351I6

Polyamide 6
Polyram Ram-On Industries

Message:
30% Glass Fiber and Mineral Reinforced Polyamide 6 for Injection Moulding applications.

General Information			
Filler / Reinforcement	Glass \mineral, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.65	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.30 - 0.70	%	ASTM D955
--	0.30 - 0.70	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	70.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus	3800	MPa	ASTM D790, ISO 178
Flexural Strength	105	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C	5.0	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	218	°C	ISO 11357-3, ASTM D3417
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.15	%	
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	
Injection Rate	Fast		
Holding Pressure	30.0 - 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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