

PLUSTEK RA102

Polyamide 66
Polyram Ram-On Industries

Message:
General Purpose Polyamide 6.6 for Injection Moulding applications.

General Information			
Features	General		
Uses	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12 - 1.14	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.5 - 1.8	%	ASTM D955
--	1.5 - 1.8	%	ISO 2577
Water Absorption			
Saturation	8.0	%	ASTM D570
Saturated, 23°C	8.0	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	> 115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	65.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 5.0	%	ASTM D638, ISO 527-2
Flexural Modulus	2400	MPa	ASTM D790, ISO 178
Flexural Strength	100	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/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	110	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	65.0	°C	ASTM D648, ISO 75-2/A
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
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Flammability	12	mm/min	FMVSS 302

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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