

PLUSTEK RD302G6

Polyamide 12
Polyram Ram-On Industries

Message:
30% GLASS-FIBER RINFORCED POLYAMIDE 12 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.16	%	ASTM D955
--	0.16	%	ISO 2577
Water Absorption			
Saturation	1.2	%	ASTM D570
Saturated, 23°C	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
--	7000	MPa	ASTM D638
--	7500	MPa	ISO 527-2
Tensile Strength (Yield)	130	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	6000	MPa	ASTM D790, ISO 178
Flexural Strength	150	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	180	J/m	ASTM D256
23°C	170	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	165 - 175	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value		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	0.10	%	
Rear Temperature	215 - 255	°C	
Middle Temperature	220 - 260	°C	

Front Temperature	225 - 265	°C
Mold Temperature	65.0 - 105	°C
Injection Pressure	70.0 - 105	MPa
Injection Rate	Fast	
Holding Pressure	35.0 - 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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