

PLUSTEK RA502

Polyamide 66

Polyram Ram-On Industries

Message:

POLYAMIDE 66, FLAME RETARDANT FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	1.0 - 1.5	%	ASTM D955
--	1.0 - 1.5	%	ISO 2577
Water Absorption			
Saturation	0.90	%	ASTM D570
Saturated, 23°C	0.90	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	> 80.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 10	%	ASTM D638, ISO 527-2
Flexural Modulus	> 2600	MPa	ASTM D790, ISO 178
Flexural Strength	> 115	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	> 40	J/m	ASTM D256
23°C	> 4.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	> 180	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	> 90.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	256	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Unit	Test Method
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

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