

PLUSTEK RA844

Polyamide 66
Polyram Ram-On Industries

Message:
IMPACT MODIFIED, UV AND HEAT STABILIZED POLYAMIDE 66 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Impact modifier		
	heat stabilizer		
	UV stabilizer		
Features	Impact modification		
	Good UV resistance		
	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	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	7.0	%	ASTM D570
Saturated, 23°C	7.0	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	%	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	1800	MPa	ISO 527-2
Tensile Strength (Yield)	50.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	30	%	ASTM D638, ISO 527-2
Flexural Modulus	1900	MPa	ASTM D790, ISO 178
Flexural Strength	80.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	18	kJ/m ²	ISO 179
23°C	22	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	250	J/m	ASTM D256
-30°C	25	kJ/m ²	ISO 180
23°C	45	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	160	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	> 180	°C	
Maximum Continuous Use Temperature	110	°C	
Melting Temperature	262	°C	ISO 11357-3, ASTM D3417
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Dielectric Strength	90	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.20		IEC 60250
Flammability	Nominal Value	Unit	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	0.15	%	
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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

