

# PLUSTEK PA303G6

Polyamide 66  
Polyram Ram-On Industries

Message:  
30% Glass Fiber Reinforced, Heat Stabilized, Hydrolysis Resistant Polyamide 6.6 for Injection Moulding applications.

| General Information               |                                                       |                |                      |
|-----------------------------------|-------------------------------------------------------|----------------|----------------------|
| UL YellowCard                     | E174094-226185                                        | E174094-226186 |                      |
| Filler / Reinforcement            | Glass fiber reinforced material, 30% filler by weight |                |                      |
| Additive                          | heat stabilizer                                       |                |                      |
| Features                          | Hydrolysis resistance                                 |                |                      |
|                                   | Thermal Stability                                     |                |                      |
| RoHS Compliance                   | RoHS compliance                                       |                |                      |
| Processing Method                 | Injection molding                                     |                |                      |
| Physical                          | Nominal Value                                         | Unit           | Test Method          |
| Specific Gravity                  | 1.37                                                  | g/cm³          | ASTM D792, ISO 1183  |
| Molding Shrinkage                 |                                                       |                |                      |
| Flow                              | 0.30 - 0.70                                           | %              | ASTM D955            |
| --                                | 0.30 - 0.70                                           | %              | ISO 2577             |
| Water Absorption                  |                                                       |                |                      |
| Saturation                        | 5.6                                                   | %              | ASTM D570            |
| Saturated, 23°C                   | 5.6                                                   | %              | ISO 62               |
| Equilibrium, 23°C, 50% RH         | 1.7                                                   | %              | ASTM D570, ISO 62    |
| Hardness                          | Nominal Value                                         | Unit           | Test Method          |
| Rockwell Hardness                 |                                                       |                |                      |
| Class r                           | 122                                                   |                | ASTM D785            |
| R scale                           | 122                                                   |                | ISO 2039-2           |
| Mechanical                        | Nominal Value                                         | Unit           | Test Method          |
| Tensile Modulus                   | 11000                                                 | MPa            | ASTM D638, ISO 527-2 |
| Tensile Strength (Yield)          | 190                                                   | MPa            | ASTM D638, ISO 527-2 |
| Tensile Elongation (Break)        | 3.5                                                   | %              | ASTM D638, ISO 527-2 |
| Flexural Modulus                  | 9000                                                  | MPa            | ASTM D790, ISO 178   |
| Flexural Strength                 | 280                                                   | MPa            | ASTM D790, ISO 178   |
| Impact                            | Nominal Value                                         | Unit           | Test Method          |
| Notched Izod Impact               |                                                       |                |                      |
| 23°C                              | 120                                                   | J/m            | ASTM D256            |
| 23°C                              | 12                                                    | kJ/m²          | ISO 180              |
| Thermal                           | Nominal Value                                         | Unit           | Test Method          |
| Deflection Temperature Under Load |                                                       |                |                      |

| 0.45 MPa, not annealed                              | 260           | °C      | ASTM D648, ISO 75-2/B   |
|-----------------------------------------------------|---------------|---------|-------------------------|
| 1.8 MPa, not annealed                               | 250           | °C      | ASTM D648, ISO 75-2/A   |
| Maximum operating temperature-Short Peaks Operation | 240           | °C      |                         |
| Maximum Continuous Use Temperature                  | 130           | °C      |                         |
| Flammability                                        | 11            | mm/min  | FMVSS 302               |
| Melting Temperature                                 | 256           | °C      | ISO 11357-3, ASTM D3417 |
| Electrical                                          | Nominal Value | Unit    | Test Method             |
| Surface Resistivity                                 | 1.0E+13       | ohms    | IEC 60093               |
| Volume Resistivity                                  | 1.0E+17       | ohms·cm | IEC 60093               |
| Dielectric Strength                                 | 90            | kV/mm   | IEC 60243-1             |
| Dielectric Constant (1 MHz)                         | 3.70          |         | IEC 60250               |
| Comparative Tracking Index                          | 400           | V       | IEC 60112               |
| Flammability                                        | Nominal Value | Unit    | Test Method             |
| Flame Rating (3.00 mm)                              | HB            |         | UL 94                   |
| Glow Wire Flammability Index                        | 750           | °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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### 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



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