PLUSTEK RA845

Polyamide 66

Polyram Ram-On Industries

Message:

IMPROVED IMPACT POLYAMIDE 66 FOR GOOD RESISTANCE TO LOW TEMP' FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	Impact resistance, good Low temperature impact resistance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.09	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	2.0	%	ASTM D955
--	2.0	%	ISO 2577
Water Absorption			
Saturation	6.0	%	ASTM D570
Saturated, 23°C	6.0	%	ISO 62
Equilibrium, 23°C, 50% RH	2.1	%	ASTM D570, ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	40	%	ASTM D638, ISO 527-2
Flexural Modulus	1950	MPa	ASTM D790, ISO 178
Flexural Strength	90.0	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	350	J/m	ASTM D256
23°C	20	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	225	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	85.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	> 180	°C	
Maximum Continuous Use Temperature	80	°C	
Melting Temperature	256	°C	ISO 11357-3, ASTM D3418
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

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

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