

PLUSTEK PD304G6YL55

Polyamide 12
Polyram Ram-On Industries

Message:
30% GLASS FIBER REINFORCED POLYAMIDE 12 FOR INJECTION MOLDING APPLICATIONS. UL LISTED MATERIAL.

General Information			
UL YellowCard	E174094-521020		
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	1.23	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.20 - 0.30	%	ASTM D955
--	0.20 - 0.30	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	120	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.5	%	ASTM D638, ISO 527-2
Flexural Modulus	5200	MPa	ASTM D790, ISO 178
Flexural Strength	160	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C	15	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	177	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	165	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165 - 175	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.60 mm	HB		
3.00 mm	HB		
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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