

PLUSTEK RA331G6

Polyamide 66
Polyram Ram-On Industries

Message:
30% GLASS-FIBER REINFORCED POLYAMIDE 66 FOR INJECTION MOULDING APPLICATIONS.

General Information			
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	1.37	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.20 - 0.30	%	ASTM D955
--	0.20 - 0.30	%	ISO 2577
Water Absorption			
Saturation	0.80	%	ASTM D570
Saturated, 23°C	0.80	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	160	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.3	%	ASTM D638, ISO 527-2
Flexural Modulus	7800	MPa	ASTM D790, ISO 178
Flexural Strength	220	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256
23°C	10	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	259	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	249	°C	ASTM D648, ISO 75-2/A
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+17	ohms · cm	IEC 60093
Dielectric Strength	90	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.50		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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