

PLUSTEK RA124

Polyamide 66

Polyram Ram-On Industries

Message:

A FAST CYCLE POLYAMIDE 66 FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	Fast molding cycle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	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	8.5	%	ASTM D570
Saturated, 23°C	8.5	%	ISO 62
Equilibrium, 23°C, 50% RH	2.8	%	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 Strength (Yield)	90.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	10	%	ASTM D638, ISO 527-2
Flexural Modulus	2000	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	45	J/m	ASTM D256
23°C	4.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	210	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	100	°C	ASTM D648
1.8 MPa, not annealed	200	°C	ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	180	°C	
Maximum Continuous Use Temperature	70	°C	
Melting Temperature	256	°C	ISO 11357-3, ASTM D3418

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.60 mm	V-2	UL 94
3.00 mm	V-2	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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