PLUSTEK RA325J5

Polyamide 66

Polyram Ram-On Industries

Message:

25% GLASS- BEADS AND GLASS-FIBER REINFORCED, FLAME RETARDANT POLYAMIDE 66 FOR INJECTION MOULDING APPLICATIONS.

General Information			
UL YellowCard	E174094-226189	E174094-463047	
Filler / Reinforcement	Glass Beads \Glass Fiber, 25% Filler by Weight		
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.35	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.50 - 0.60	%	ASTM D955
--	0.50 - 0.60	%	ISO 2577
Water Absorption			
Saturation	6.0	%	ASTM D570
Saturated, 23°C	6.0	%	ISO 62
Equilibrium, 23°C, 50% RH	1.9	%	ASTM D570, ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	5000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	75.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	6.0	%	ASTM D638, ISO 527-2
Flexural Modulus	3700	MPa	ASTM D790, ISO 178
Flexural Strength	130	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	40	J/m	ASTM D256
23°C	4.0	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Melting Temperature	256	°C	ISO 11357-3, ASTM D3418
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	80	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.70		IEC 60250
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (3.00 mm)	V-0		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

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