

UBE PAE1200U Nylon Elastomer

Category : Polymer , Thermoplastic , Nylon

Material Notes:

Description: UBESTA Nylon 12 Elastomer Information provided by UBE.

Order this product through the following link:

http://www.lookpolymers.com/polymer_UBE-PAE1200U-Nylon-Elastomer.php

Physical Properties	Metric	English	Comments
Density	1.00 g/cc	0.0361 lb/in ³	ASTM D792
Melt Flow	14 g/10 min @Load 2.16 kg, Temperature 235 °C	14 g/10 min @Load 4.76 lb, Temperature 455 °F	ASTM D1238R

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	58	58	
Tensile Strength, Yield	9.00 MPa	1310 psi	ASTM D638
Elongation at Break	>= 300 %	>= 300 %	ASTM D638
Flexural Strength	7.00 MPa	1020 psi	ASTM D790
Flexural Modulus	0.150 GPa	21.8 ksi	ASTM D790
Izod Impact, Notched	NB	NB	ASTM D256

Thermal Properties	Metric	English	Comments
Melting Point	154 °C	309 °F	ASTM D3418
Deflection Temperature at 0.46 MPa (66 psi)	82.0 °C	180 °F	ASTM D648

Processing Properties	Metric	English	Comments
Injection Velocity	100 mm/sec	3.94 in/sec	Injection Molding
Die Opening	0.0400 cm	0.0157 in	For T-Die Cast Film Extrusion

Descriptive Properties	Value	Comments
C/R	3-3.5:1	For 8x1 mm Tube Extrusion
Calibrating Vacuum	100 mbar	For 8x1 mm Tube Extrusion
Calibration	9.95 mm	For 8x1 mm Tube Extrusion

Descriptive Properties	Value	Comments
Compression Ratio	2.3-3.5:1	Injection Molding
	min 3:1	For 8x1 mm Tube Extrusion
Die Diameter	16 mm	For 8x1 mm Tube Extrusion
Die Width	300 mm	For T-Die Cast Film Extrusion
Extruder	Barmag, Screw Diameter = 30 mm	For T-Die Cast Film Extrusion
Extruder Characteristics	65 mm screw diameter	For 8x1 mm Tube Extrusion
Film Thickness	60 microns	For T-Die Cast Film Extrusion
Flight Depth in the Feeding Zone	10-15% of Screw Diameter	Injection Molding
Flight Depth in the Metering Zone	5-7% of Screw Diameter	Injection Molding
Haul Off Speed	5 m/min	For T-Die Cast Film Extrusion
Haul Speed	10-55 m/min	For 8x1 mm Tube Extrusion
L/D Ratio	25:1	For 8x1 mm Tube Extrusion
	min 20:1	Injection Molding
Length of Compression Zone	25-45% of total screw length	Injection Molding
	30% of screw length	For 8x1 mm Tube Extrusion
Length of Feeding Zone	20-40% of total screw length	Injection Molding
	30-40% of screw length	For 8x1 mm Tube Extrusion
Length of Metering Zone	30-45% of screw length	For 8x1 mm Tube Extrusion
	35-45% of total screw length	Injection Molding
Mandrel Diameter	12 mm	For 8x1 mm Tube Extrusion
Peripheral screw speed	10 m/min	Injection Molding
Water Temperature	10-18°C	For 8x1 mm Tube Extrusion

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