

TECHNICAL DATASHEET

TRAMID[®] 923G25

Polyamide

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.33
Water Absorption (24 hours at 23°C)	%	D570	0.9
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,600
Tensile Elongation at break	%	D638	3
Flexural Strength at yield	kg _f /cm ²	D790	2,100
Flexural Modulus	kg _f /cm ²	D790	66,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	7
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	246
ELECTRICAL			
Dielectric Strength	kV/mm	D149	17
OTHERS			
Mold Shrinkage	%		0.6~0.9

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRAMID® 923G25 GRADE

Polyamide

- General processing conditions for TRAMID923G25 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	120
Drying Time	hr	5~7
Moisture Content, Max	%	0.2
Melt Temperature	℃	275-290
Nozzle Temperature	℃	275-290
Front Temperature	℃	275-290
Middle Temperature	℃	275-290
Rear Temperature	℃	275-290
Mold Temperature	℃	0-95
Back Pressure	MPa	0.1-0.5
Screw Speed	rpm	30-70
Injection Pressure	MPa	40-100
Injection Speed	%	30-70
Hold Pressure	MPa	30-80
Injection Cushion	mm	2.5-3.5

Global Network

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