

AURUM[®] PL500A, PD500A

Thermoplastic Polyimide

AURUM[®] PL500A and PD500A are thermoplastic polyamide of Tg=253°C.

PD500A : powder, PL500A : granule

General Properties	Typical value	Unit	Test method
Specific gravity	1.33	-	ASTM D792
MFR, 400°C-1.05kgf	5	g/10min	ASTM D1238
Mold shrinkage (MD/TD)	0.7 / 0.8	%	Mitsui chemical method

Mechanical Properties	Typical value	Unit	Test method
Tensile strength	90	MPa	ASTM D638
Elongation at brake	70	%	ASTM D638
Flexural strength	140	MPa	ASTM D790
Flexural modulus	3	GPa	ASTM D790
Izod impact strength	120	J/m	ASTM D256

Thermal properties	Typical value	Unit	Test method
HDT	235	°C	ASTM D648
CLTE (MD/TD)	5.5 / 5.5	10 ⁻⁵ /°C	ASTM D696

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Injection molding condition

Drying temperature	200	°C
Drying time	> 5	h
Temperature setting	80	°C
Cylinder 1	390-400	°C
Cylinder 2	400-410	°C
Cylinder 3	400-410	°C
Nozzle Temperature	400-410	°C
Mold Temperature	180-200	°C