

**RamLloy PNS303PWG6BK11**

(PPE+PS)-GF30

Polyram

| Processing/Physical Characteristics                | Value     | Unit                   | Test Standard   |
|--|-----------|------------------------|-----------------|
| <b>ISO Data</b>                                    |           |                        |                 |
| Melt volume-flow rate, MVR                         | 4.6       | cm <sup>3</sup> /10min | ISO 1133        |
| Temperature  | 280       | °C                     | -               |
| Load   | 5         | kg                     | -               |
| Molding shrinkage, parallel                        | 0.2       | %                      | ISO 294-4, 2577 |
| Molding shrinkage, normal                          | 0.3       | %                      | ISO 294-4, 2577 |
| <b>Mechanical properties</b>                       |           |                        |                 |
| <b>ISO Data</b>                                    |           |                        |                 |
| Tensile Modulus                                    | 9260      | MPa                    | ISO 527         |
| Tensile Strength                                   | 120       | MPa                    | ISO 527         |
| Strain at break                                    | 1.8       | %                      | ISO 527         |
| Flexural modulus, 23°C                             | 9000      | MPa                    | ISO 178         |
| Flexural strength                                  | 200       | MPa                    | ISO 178         |
| Izod impact strength, +23°C                        | 30        | kJ/m <sup>2</sup>      | ISO 180/1U      |
| Izod notched impact strength, +23°C                | 9.5       | kJ/m <sup>2</sup>      | ISO 180/1A      |
| Izod notched impact strength                       | 10        | kJ/m <sup>2</sup>      | ISO 180/1A      |
| Temperature  | -30       | °C                     | -               |
| <b>ASTM Data</b>                                   |           |                        |                 |
| Shore D Hardness                                   | 90        | -                      | ASTM D 2240     |
| <b>Thermal properties</b>                          |           |                        |                 |
| <b>ISO Data</b>                                    |           |                        |                 |
| Temp. of deflection under load, 1.80 MPa           | 145       | °C                     | ISO 75-1/-2     |
| <b>ASTM Data</b>                                   |           |                        |                 |
| Vicat Temperature                                  | 165       | °C                     | ASTM D 1525     |
| <b>Other properties</b>                            |           |                        |                 |
| Density  | 1300      | kg/m <sup>3</sup>      | ISO 1183        |
| <b>Processing Recommendation Injection Molding</b> |           |                        |                 |
| Pre-drying - Temperature                           | 100 - 120 | °C                     | -               |
| Pre-drying - Time                                  | 2 - 4     | h                      | -               |
| Processing humidity                                | ≤0.02     | %                      | -               |
| Mold temperature                                   | 80 - 100  | °C                     | -               |
| Feed temperature                                   | 60 - 80   | °C                     | -               |
| Zone 1   | 250 - 270 | °C                     | -               |
| Zone 2   | 270 - 290 | °C                     | -               |
| Zone 3   | 280 - 300 | °C                     | -               |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

U.V. stabilized or stable to weather

**Certifications**Food contact, Drinking water contact, Drinking water contact  
NSF 61**Regional Availability**North America, Europe, Asia Pacific, South and Central America,  
Near East/Africa