

RamSter PF310G6BK11

(PBT+PET)-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	60	g/10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	0.1	%	Producer Method
Molding shrinkage, normal	0.5	%	Producer Method

S: These properties are reported by the producer according standards that are different to our defaults.

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	10600	MPa	ISO 527
Tensile Strength	140	MPa	ISO 527
Strain at break	2.3	%	ISO 527
Flexural modulus, 23°C	9000	MPa	ISO 178
Flexural strength	207	MPa	ISO 178
Charpy impact strength, +23°C	58	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	55	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	7	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	7.5	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10	kJ/m ²	ISO 180/1A
Izod notched impact strength	7.7	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Shore D Hardness	85	-	ASTM D 2240

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	192	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2
Burning rate, FMVSS, Thickness 1 mm	100	mm/min	ISO 3795 (FMVSS 302)

Other properties	Value	Unit	Test Standard
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1550	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Mold temperature	90 - 120	°C	-
Feed temperature	40 - 60	°C	-
Zone 1	240 - 260	°C	-
Zone 2	250 - 260	°C	-
Zone 3	260 - 270	°C	-

Characteristics**Processing**

Injection Molding

Certifications

RoHS compliant

Delivery form

Black

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Special Characteristics

U.V. stabilized or stable to weather