

RamSter PF310G6BK10-7.1

(PBT+PET)-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	16	g/10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	0.1	%	Producer Method
Molding shrinkage, normal	0.6	%	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	9800	MPa	ISO 527
Tensile Strength	135	MPa	ISO 527
Strain at break	2.6	%	ISO 527
Flexural modulus, 23°C	9150	MPa	ISO 178
Flexural strength	215	MPa	ISO 178
Charpy impact strength, +23°C	60	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	8.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	182	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	218	°C	ISO 75-1/-2
Burning rate, FMVSS, Thickness 1 mm	100	mm/min	ISO 3795 (FMVSS 302)
ASTM Data			
Vicat Temperature	223	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1520	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

Delivery form

Black

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

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