

**RamSter PF310G9BK11**

(PBT+PET)-GF45

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
<b>Other Standards<sup>[S]</sup></b>			
Molding shrinkage, parallel	0.2	%	Producer Method
Molding shrinkage, normal	0.7	%	Producer Method

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

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	14900	MPa	ISO 527
Tensile Strength	145	MPa	ISO 527
Strain at break	2.1	%	ISO 527
Flexural modulus, 23°C	13600	MPa	ISO 178
Flexural strength	240	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	9	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	12	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	218	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1670	kg/m <sup>3</sup>	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**

U.V. stabilized or stable to weather

**Certifications**

RoHS compliant

**Applications**

Automotive

**Regional Availability**

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