

RamSter PF344J6BK10

PBT-(GF+GB)30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	22.5	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	0.6	%	Producer Method
Molding shrinkage, normal	1.1	%	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	6050	MPa	ISO 527
Tensile Strength	79	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Charpy impact strength, +23°C	25.5	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	26	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	4.4	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.3	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	4.5	kJ/m ²	ISO 180/1A
Izod notched impact strength	4.3	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	190	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	210	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Burning rate, FMVSS, Thickness 1 mm	100	mm/min	ISO 3795 (FMVSS 302)

Other properties	Value	Unit	Test Standard
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1530	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	≤0.04	%	-
Mold temperature	70 - 90	°C	-
Feed temperature	40 - 60	°C	-
Zone 1	245 - 255	°C	-
Zone 2	245 - 255	°C	-
Zone 3	250 - 260	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Black

Applications

Automotive

Regional Availability

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