

**RamSter PF300J50BK10**

PBT-(GF+GB)50

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	12	g/10min	ISO 1133
Temperature	250	°C	-
Load	5	kg	-
<b>Other Standards<sup>[S]</sup></b>			
Molding shrinkage, parallel	0.2	%	Producer Method
Molding shrinkage, normal	0.3	%	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	13100	MPa	ISO 527
Tensile Strength	126	MPa	ISO 527
Strain at break	1.9	%	ISO 527
Izod notched impact strength, +23°C	12.5	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Izod Impact notched, 1/8 in	125	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	205	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
<b>ASTM Data</b>			
Vicat Temperature	220	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1720	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	≤0.04	%	-
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

**Certifications**

RoHS compliant

**Delivery form**

Black

**Regional Availability**

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