

RamSter PF521G2OR81

PBT-GF10

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	1.1	%	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	5000	MPa	ISO 527
Tensile Strength	82	MPa	ISO 527
Strain at break	3.5	%	ISO 527
Charpy notched impact strength, +23°C	7	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	7	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	175	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.4	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1550	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120 - 130	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Mold temperature	65 - 95	°C	-
Feed temperature	20 - 50	°C	-
Zone 1	230 - 240	°C	-
Zone 2	235 - 250	°C	-
Zone 3	240 - 255	°C	-

Characteristics**Processing**

Injection Molding

Applications

Automotive, Electrical and Electronical

Special Characteristics

Flame retardant

Regional Availability

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