

RamSter PF313G3GR21

PBT-GF15

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
Other Standards^{S1}			
Molding shrinkage, parallel	0.5	%	Producer Method
Molding shrinkage, normal	1.0	%	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	5370	MPa	ISO 527
Tensile Strength	95	MPa	ISO 527
Strain at break	2.9	%	ISO 527
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	0.5	%	Sim. to ISO 62
Humidity absorption	0.25	%	Sim. to ISO 62
Density	1420	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

Certifications

RoHS compliant

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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