

RamSter PF318G3GR436

PBT-GF15

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	12	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
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	6000	MPa	ISO 527
Tensile Strength	105	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Flexural modulus, 23°C	4800	MPa	ISO 178
Flexural strength	165	MPa	ISO 178
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	186	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	217	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	1430	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	≤0.02	%	-
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

Regional Availability

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