

RamSter PF321G3BK10

PBT-GF15

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
Other Standards^{S1}			
Molding shrinkage, parallel	0.4	%	Producer Method
Molding shrinkage, normal	0.8	%	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	5650	MPa	ISO 527
Tensile Strength	100	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Izod notched impact strength, +23°C	5.5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	200	°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-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.6	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1520	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	235 - 255	°C	-
Zone 2	235 - 255	°C	-
Zone 3	240 - 260	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Black

Special Characteristics

Flame retardant

Regional Availability

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