

RamSter PF332G3SI4

PBT-GF15

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	82	cm ³ /10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Melt flow index, MFI	8	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	6700	MPa	ISO 527
Tensile Strength	100	MPa	ISO 527
Strain at break	2.7	%	ISO 527
Izod notched impact strength, +23°C	6	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	165	°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	≤0.04	%	-
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

Regional Availability

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