

RamSter PF321G4NT

PBT-GF20

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	0.3	%	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	7900	MPa	ISO 527
Tensile Strength	125	MPa	ISO 527
Strain at break	3	%	ISO 527
Izod notched impact strength, +23°C	8.6	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
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	1550	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

Natural Color

Special Characteristics

Flame retardant

Certifications

RoHS compliant

Regional Availability

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