

RamSter PF394G4BK10

PBT-GF20

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	8.5	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	0.3	%	Producer Method
Molding shrinkage, normal	0.9	%	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	6700	MPa	ISO 527
Tensile Strength	103	MPa	ISO 527
Strain at break	3	%	ISO 527
Izod notched impact strength, +23°C	11.7	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
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

Food contact, Food approval 10/2011, RoHS compliant

Delivery form

Black

Regional Availability

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