

**RamSter PF311G6BK10**

PBT-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	13	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
<b>Other Standards<sup>[S]</sup></b>			
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
<b>ISO Data</b>			
Tensile Modulus	9400	MPa	ISO 527
Tensile Strength	133	MPa	ISO 527
Strain at break	2.7	%	ISO 527
Charpy notched impact strength, +23°C	11	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 0.45 MPa	205	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.1	%	Sim. to ISO 62
Density	1530	kg/m <sup>3</sup>	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

**Delivery form**

Black

**Chemical Resistance**

Hydrolytically Stable

**Applications**

Automotive

**Regional Availability**

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