

**RamSter PF321G6BK10**

PBT-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	7	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
<b>Other Standards<sup>[S]</sup></b>			
Molding shrinkage, parallel	0.2	%	Producer Method
Molding shrinkage, normal	0.5	%	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	10700	MPa	ISO 527
Tensile Strength	135	MPa	ISO 527
Strain at break	2.4	%	ISO 527
Flexural modulus, 23°C	9000	MPa	ISO 178
Flexural strength	200	MPa	ISO 178
Charpy impact strength, +23°C	58	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	9	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
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	-
Burning behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	1.6	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.5	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1640	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	≤0.02	%	-
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

**Certifications**

RoHS compliant

**Regional Availability**

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

**Special Characteristics**

Flame retardant