

**RamSter PF391G6BK10**

PBT-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>11.2</b>	g/10min	ISO 1133
Temperature	<b>250</b>	°C	-
Load	<b>2.16</b>	kg	-
<b>Other Standards<sup>[S]</sup></b>			
Molding shrinkage, parallel	<b>0.2</b>	%	Producer Method
Molding shrinkage, normal	<b>0.6</b>	%	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	<b>9440</b>	MPa	ISO 527
Tensile Strength	<b>129</b>	MPa	ISO 527
Strain at break	<b>2.8</b>	%	ISO 527
Izod notched impact strength, +23°C	<b>12.7</b>	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Burning rate, FMVSS, Thickness 1 mm	<b>100</b>	mm/min	ISO 3795 (FMVSS 302)

Other properties	Value	Unit	Test Standard
Water absorption	<b>0.4</b>	%	Sim. to ISO 62
Humidity absorption	<b>0.2</b>	%	Sim. to ISO 62
Density	<b>1530</b>	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>120</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Processing humidity	<b>≤0.04</b>	%	-
Mold temperature	<b>70 - 90</b>	°C	-
Feed temperature	<b>40 - 60</b>	°C	-
Zone 1	<b>245 - 255</b>	°C	-
Zone 2	<b>245 - 255</b>	°C	-
Zone 3	<b>250 - 260</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Certifications**

RoHS compliant

**Applications**

Automotive

**Regional Availability**

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