

**RamSter PF391G6GN31**

PBT-GF30

Polyram

| Processing/Physical Characteristics  | Value | Unit    | Test Standard   |
|--------------------------------------|-------|---------|-----------------|
| <b>ISO Data</b>                      |       |         |                 |
| Melt flow index, MFI                 | 9.5   | 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            | 0.6   | %       | 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                     | 9460  | MPa               | ISO 527       |
| Tensile Strength                    | 110   | MPa               | ISO 527       |
| Strain at break                     | 1.8   | %                 | ISO 527       |
| Izod notched impact strength, +23°C | 8.1   | kJ/m <sup>2</sup> | 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             | 1510  | 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

**Certifications**

RoHS compliant

**Regional Availability**

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