

**RamSter PF800G6GR399**

PBT-GF30

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	1.45	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	0.2	%	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	8900	MPa	ISO 527
Tensile Strength	110	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Flexural modulus, 23°C	7760	MPa	ISO 178
Flexural strength	180	MPa	ISO 178
Charpy impact strength, +23°C	68	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	64	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	10	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	16	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Izod Impact notched, 1/8 in	162	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	125	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	201	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Water absorption	0.1	%	Sim. to ISO 62
Humidity absorption	0.07	%	Sim. to ISO 62
Density	1450	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 - 250	°C	-
Zone 2	235 - 255	°C	-
Zone 3	240 - 260	°C	-

**Characteristics****Processing**

Injection Molding

**Certifications**

RoHS compliant

**Special Characteristics**

High impact or impact modified

**Applications**

Automotive

**Features**

Good Adhesion

**Regional Availability**

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