

RamSter PF100NT

PBT

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	18	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	1.8	%	Producer Method

S: These properties are reported by the producer according standards that are different to our defaults.

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2700	MPa	ISO 527
Tensile Strength	58	MPa	ISO 527
Yield strain	10	%	ISO 527
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	60	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	152	°C	ISO 75-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
Vicat Temperature	220	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Humidity absorption	0.6	%	Sim. to ISO 62
Density	1310	kg/m ³	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

Natural Color

Certifications

Food contact, Food approval 10/2011, RoHS compliant

Applications

General Purpose

Regional Availability

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