

RamSter PF316G33BK10

PBT-GF33

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	13.6	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
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
ISO Data			
Tensile Modulus	10600	MPa	ISO 527
Tensile Strength	135	MPa	ISO 527
Strain at break	2.7	%	ISO 527
Flexural modulus, 23°C	8990	MPa	ISO 178
Flexural strength	218	MPa	ISO 178
Izod notched impact strength, +23°C	12.3	kJ/m ²	ISO 180/1A
Izod notched impact strength	10.5	kJ/m ²	ISO 180/1A
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	205	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	222	°C	ISO 75-1/-2
Burning rate, FMVSS, Thickness 1 mm	100	mm/min	ISO 3795 (FMVSS 302)

Electrical properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	400	-	IEC 60112

Other properties	Value	Unit	Test Standard
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1530	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	≤0.04	%	-
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

Delivery form

Black

Special Characteristics

High impact or impact modified

Regional Availability

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