

**RamTal PM1020BK19**

POM

Polyram

| Processing/Physical Characteristics | Value       | Unit    | Test Standard   |
|-------------------------------------|-------------|---------|-----------------|
| <b>ISO Data</b>                     |             |         |                 |
| Melt flow index, MFI                | <b>20</b>   | g/10min | ISO 1133        |
| Temperature                         | <b>190</b>  | °C      | -               |
| Load                                | <b>2.16</b> | kg      | -               |
| Molding shrinkage, parallel         | <b>1.9</b>  | %       | ISO 294-4, 2577 |

| Mechanical properties               | Value       | Unit              | Test Standard |
|-------------------------------------|-------------|-------------------|---------------|
| <b>ISO Data</b>                     |             |                   |               |
| Tensile Modulus                     | <b>2800</b> | MPa               | ISO 527       |
| Tensile Strength                    | <b>60</b>   | MPa               | ISO 527       |
| Yield strain                        | <b>10</b>   | %                 | ISO 527       |
| Izod notched impact strength, +23°C | <b>6.5</b>  | kJ/m <sup>2</sup> | ISO 180/1A    |

| Other properties    | Value       | Unit              | Test Standard  |
|---------------------|-------------|-------------------|----------------|
| Water absorption    | <b>0.8</b>  | %                 | Sim. to ISO 62 |
| Humidity absorption | <b>0.2</b>  | %                 | Sim. to ISO 62 |
| Density             | <b>1410</b> | kg/m <sup>3</sup> | ISO 1183       |

| Processing Recommendation Injection Molding | Value            | Unit | Test Standard |
|---|------------------|------|---------------|
| Pre-drying - Temperature                    | <b>80</b>        | °C   | -             |
| Pre-drying - Time                           | <b>2 - 4</b>     | h    | -             |
| Processing humidity                         | <b>≤0.15</b>     | %    | -             |
| Mold temperature                            | <b>60 - 90</b>   | °C   | -             |
| Feed temperature                            | <b>60 - 70</b>   | °C   | -             |
| Zone 1                                      | <b>170 - 180</b> | °C   | -             |
| Zone 2                                      | <b>180 - 190</b> | °C   | -             |
| Zone 3                                      | <b>180 - 190</b> | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Certifications**

RoHS compliant

**Regional Availability**

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