RamTal PM1113BK10

POM — Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**15.5**	g/10min	ISO 1133
Temperature	**190**	°C	-
Load	**2.16**	kg	-
Molding shrinkage, parallel	**1.9**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2800**	MPa	ISO 527
Tensile Strength	**62**	MPa	ISO 527
Yield strain	**10**	%	ISO 527
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**8.3**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**7.6**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**6.5**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**167**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**86**	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.6**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**0.8**	mm	-
ASTM Data			
Vicat Temperature	**164**	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Water absorption	**0.8**	%	Sim. to ISO 62
Humidity absorption	**0.2**	%	Sim. to ISO 62
Density	**1410**	kg/m³	ISO 1183

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

Characteristics

Processing
Injection Molding

Certifications
RoHS compliant

Delivery form
Black

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