

**RamSter PF300G3BK11**

PBT-GF15

Polyram

| Processing/Physical Characteristics  | Value       | Unit    | Test Standard   |
|--------------------------------------|-------------|---------|-----------------|
| <b>ISO Data</b>                      |             |         |                 |
| Melt flow index, MFI                 | <b>12.5</b> | g/10min | ISO 1133        |
| Temperature                          | <b>250</b>  | °C      | -               |
| Load                                 | <b>2.16</b> | kg      | -               |
| <b>Other Standards<sup>[S]</sup></b> |             |         |                 |
| Molding shrinkage, parallel          | <b>0.6</b>  | %       | Producer Method |
| Molding shrinkage, normal            | <b>1.0</b>  | %       | 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                     | <b>5700</b> | MPa               | ISO 527       |
| Tensile Strength                    | <b>95</b>   | MPa               | ISO 527       |
| Strain at break                     | <b>3.1</b>  | %                 | ISO 527       |
| Izod notched impact strength, +23°C | <b>11</b>   | kJ/m <sup>2</sup> | ISO 180/1A    |

| Thermal properties                  | Value      | Unit  | Test Standard   |
|-------------------------------------|------------|-------|-----------------|
| <b>ISO Data</b>                     |            |       |                 |
| Burning behav. at thickness h       | <b>HB</b>  | class | IEC 60695-11-10 |
| Thickness tested                    | <b>3.0</b> | mm    | -               |
| Glow Wire Flammability Index (GWFI) | <b>650</b> | °C    | IEC 60695-2-12  |

| Other properties    | Value       | Unit              | Test Standard  |
|---------------------|-------------|-------------------|----------------|
| Water absorption    | <b>0.4</b>  | %                 | Sim. to ISO 62 |
| Humidity absorption | <b>0.2</b>  | %                 | Sim. to ISO 62 |
| Density             | <b>1400</b> | kg/m <sup>3</sup> | ISO 1183       |

| Processing Recommendation Injection Molding | Value            | Unit | Test Standard |
|---|------------------|------|---------------|
| Pre-drying - Temperature                    | <b>120</b>       | °C   | -             |
| Pre-drying - Time                           | <b>3 - 4</b>     | h    | -             |
| Processing humidity                         | <b>≤0.04</b>     | %    | -             |
| Mold temperature                            | <b>70 - 90</b>   | °C   | -             |
| Feed temperature                            | <b>40 - 60</b>   | °C   | -             |
| Zone 1                                      | <b>245 - 255</b> | °C   | -             |
| Zone 2                                      | <b>245 - 255</b> | °C   | -             |
| Zone 3                                      | <b>250 - 260</b> | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

U.V. stabilized or stable to weather

**Certifications**

RoHS compliant

**Regional Availability**

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