

RamSter PF717PU18

PBT

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	1.3	%	Producer Method
Molding shrinkage, normal	1.5	%	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	2600	MPa	ISO 527
Tensile Strength	56	MPa	ISO 527
Yield strain	3.5	%	ISO 527
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Humidity absorption	0.6	%	Sim. to ISO 62
Density	1320	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

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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