

**RamTal PM1109RD45M**

POM

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>10</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

**Certifications**

RoHS compliant

**Regional Availability**

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