

**RamLloy PZF103NT**  
(PC+PBT)

Polyram

| Processing/Physical Characteristics | Value | Unit    | Test Standard   |
|-------------------------------------|-------|---------|-----------------|
| <b>ISO Data</b>                     |       |         |                 |
| Melt flow index, MFI                | 32    | g/10min | ISO 1133        |
| Temperature                         | 260   | °C      | -               |
| Load                                | 5     | kg      | -               |
| Molding shrinkage, parallel         | 0.8   | %       | ISO 294-4, 2577 |
| Molding shrinkage, normal           | 0.9   | %       | ISO 294-4, 2577 |

| Mechanical properties                 | Value | Unit              | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                       |       |                   |               |
| Tensile Modulus                       | 2200  | MPa               | ISO 527       |
| Tensile Strength                      | 52    | MPa               | ISO 527       |
| Yield strain                          | 4.5   | %                 | ISO 527       |
| Strain at break                       | >50   | %                 | ISO 527       |
| Flexural modulus, 23°C                | 2100  | MPa               | ISO 178       |
| Flexural strength                     | 83    | MPa               | ISO 178       |
| Charpy notched impact strength, +23°C | 60    | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Charpy notched impact strength, -30°C | 16.5  | kJ/m <sup>2</sup> | ISO 179/1eA   |

| Other properties | Value | Unit              | Test Standard  |
|------------------|-------|-------------------|----------------|
| Water absorption | 0.2   | %                 | Sim. to ISO 62 |
| Density          | 1210  | kg/m <sup>3</sup> | ISO 1183       |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 110       | °C   | -             |
| Pre-drying - Time                           | 4 - 6     | h    | -             |
| Processing humidity                         | ≤0.02     | %    | -             |
| Mold temperature                            | 65 - 90   | °C   | -             |
| Feed temperature                            | 100 - 120 | °C   | -             |
| Zone 1                                      | 245 - 265 | °C   | -             |
| Zone 2                                      | 250 - 270 | °C   | -             |
| Zone 3                                      | 255 - 275 | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Natural Color

**Special Characteristics**

High impact or impact modified

**Regional Availability**

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