

RAMTAL PM1509

Acetal (POM) Copolymer

Polyram Ram-On Industries

Message:

POLYACETAL COPOLYMER FOR DECREASED FRICTION AND IMPROVED WEAR RESISTANCE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	Good wear resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.8 - 2.2	%	ASTM D955
--	1.8 - 2.2	%	ISO 2577
Water Absorption			
Saturation	0.22	%	ASTM D570
Saturated, 23°C	0.22	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	80		ASTM D785
R scale	80		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	50	%	ASTM D638, ISO 527-2
Flexural Modulus	2500	MPa	ASTM D790, ISO 178
Flexural Strength	75.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	75	J/m	ASTM D256
23°C	7.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	160	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	110	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	24	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.80		IEC 60250

Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	175 - 200	°C	
Middle Temperature	180 - 205	°C	
Front Temperature	190 - 210	°C	
Mold Temperature	60.0 - 110	°C	
Injection Pressure	70.0 - 105	MPa	
Holding Pressure	35.0 - 85.0	MPa	
Back Pressure	0.350 - 0.700	MPa	
Screw Speed	60 - 90	rpm	
Injection instructions			

Fill Speed: 25 to 50 mm/sec

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