

RAMTAL PM7109

Acetal (POM) Copolymer
Polyram Ram-On Industries

Message:
UV Stabilized Polyacetal Copolymer for Injection Moulding applications. MFI 9.

General Information			
Additive	UV Stabilizer		
Features	Good UV Resistance		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	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 to 2.2	%	
--	1.8 to 2.2	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	82		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2350	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			ASTM D638, ISO 527-2
Yield	10	%	
Break	20	%	
Flexural Modulus	2600	MPa	ASTM D790, ISO 178
Flexural Strength	80.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	7.5	kJ/m ²	
23°C	8.5	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	180	kJ/m ²	
23°C	170	kJ/m ²	
Notched Izod Impact			
-30°C	70	J/m	ASTM D256
23°C	80	J/m	ASTM D256
-30°C	7.0	kJ/m ²	ISO 180
23°C	7.5	kJ/m ²	ISO 180

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	150	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	90.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	172	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms·cm	IEC 60093
Electric 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
Flammability	30	mm/min	FMVSS 302
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	175 to 200	°C	
Middle Temperature	180 to 205	°C	
Front Temperature	190 to 210	°C	
Mold Temperature	60.0 to 110	°C	
Injection Pressure	70.0 to 105	MPa	
Holding Pressure	35.0 to 85.0	MPa	
Back Pressure	0.350 to 0.700	MPa	
Screw Speed	60 to 90	rpm	

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