

RAMSTER PF340S6

Polybutylene Terephthalate

Polyram Ram-On Industries

Message:

30% GLASS-BEADS REINFORCED PBT FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass beads, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.53	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
250°C/2.16 kg	15	g/10 min	ASTM D1238
300°C/1.2 kg	15	g/10 min	ISO 1133
Molding Shrinkage			
Flow	1.7	%	ASTM D955
--	1.7	%	ISO 2577
Water Absorption			
Saturation	0.50	%	ASTM D570
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.15	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3700	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	57.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	2300	MPa	ASTM D790, ISO 178
Flexural Strength	95.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	3.0	kJ/m ²	ISO 179
23°C	3.5	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	20	kJ/m ²	ISO 179
23°C	23	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	35	J/m	ASTM D256
-30°C	3.0	kJ/m ²	ISO 180
23°C	3.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, not annealed	210	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	100	°C	ASTM D648, ISO 75-2/A
Melting Temperature	225	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	25	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.60		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Glow Wire Flammability Index	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	235 - 255	°C	
Middle Temperature	240 - 260	°C	
Front Temperature	245 - 270	°C	
Processing (Melt) Temp	240 - 270	°C	
Mold Temperature	70.0 - 90.0	°C	
Injection Pressure	70.0 - 105	MPa	
Holding Pressure	30.0 - 105	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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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