

RAMSTER PF300G4

Polybutylene Terephthalate

Polyram Ram-On Industries

Message:

20% GLASS-FIBER REINFORCED PBT FOR INJECTION MOULDING APPLICATIONS.(Attached document: ISO test)

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	20	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.35	%	ASTM D955
--	0.40	%	ISO 2577
Water Absorption			
Saturation	0.50	%	ASTM D570
Saturated, 23°C	0.15	%	ISO 62
Equilibrium, 23°C, 50% RH	0.10	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6600	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	115	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	5000	MPa	ASTM D790, ISO 178
Flexural Strength	155	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	7.0	kJ/m ²	ISO 179
23°C	11	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	62	kJ/m ²	ISO 179
23°C	70	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	85	J/m	ASTM D256
23°C	9.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, not annealed	220	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	210	°C	ASTM D648, ISO 75-2/A
Melting Temperature	225	°C	ISO 11357-3, ASTM D3417
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	34	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.60		IEC 60250
Comparative Tracking Index	350	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Glow Wire Flammability Index	750	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	650	°C	IEC 60695-2-13
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

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

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



WECHAT