

RAMSTER PF329G4

Polybutylene Terephthalate

Polyram Ram-On Industries

Message:

20% GLASS-FIBER REINFORCED, HALOGEN FREE FLAME RETARDNAT PBT FOR INJECTION MOULDING APPLICATIONS.

General Information			
UL YellowCard	E174094-226193		
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	Flame retardancy		
Features	Halogen-free		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	3.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.6	%	ASTM D955
--	1.6	%	ISO 2577
Water Absorption			
Saturation	0.50	%	ASTM D570
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	87.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus	6000	MPa	ASTM D790, ISO 178
Flexural Strength	135	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	70	J/m	ASTM D256
23°C	7.0	kJ/m²	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 D3418
Electrical	Nominal Value	Unit	Test Method

Volume Resistivity	1.0E+18	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-0		UL 94
Glow Wire Flammability Index	960	°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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