

RAMTAL PM8515

Acetal (POM) Copolymer
Polyram Ram-On Industries

Message:
HIGH IMPACT POLYACETAL FOR INJECTION MOULDING APPLICATIONS, MFI 13.

General Information			
Additive	Impact Modifier		
Features	High Impact Resistance		
	Impact Modified		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	13	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)	75		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	40.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	120	%	ASTM D638, ISO 527-2
Flexural Modulus	1250	MPa	ASTM D790, ISO 178
Flexural Strength	50.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	160	J/m	ASTM D256
23°C	14	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	110	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	85.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Electric Strength	24	kV/mm	IEC 60243-1

Dielectric Constant (1 MHz)	4.20	IEC 60250
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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