

RAMTAL PM7013G2

Acetal (POM) Copolymer

Polyram Ram-On Industries

Message:

10% GLASS FIBER REINFORCED AND UV STABILIZED PLOYACETAL FOR INJECTION MOULDING APPLICATONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	UV stabilizer		
Features	Good UV resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.70 - 1.2	%	ASTM D955
--	0.70 - 1.2	%	ISO 2577
Water Absorption (Saturation)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	70.0	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	3000	MPa	ASTM D790
Flexural Strength	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	50	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Peak Melting Temperature	165	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms · cm	IEC 60093
Dielectric Strength	20	kV/mm	IEC 60243-1
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	175 - 200	°C	
Middle Temperature	180 - 205	°C	
Front Temperature	190 - 210	°C	
Mold Temperature	60.0 - 110	°C	
Injection Pressure	70.0 - 105	MPa	

Holding Pressure	35.0 - 85.0	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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Recommended distributors for this material

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