RAMSTER PF321G6

Polybutylene Terephthalate + PET

Polyram Ram-On Industries

Message:

30% GLASS FIBER REINFORCED, FALME RETARDANT PBT/PET FOR INJECTION MOULDING APPLICATION.

General Information			
UL YellowCard	E174094-100771305	E174094-100771306	
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Flame retardancy		
Features	Flame retardancy		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.68	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	10	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.20	%	ASTM D955
--	0.20	%	ISO 2577
Water Absorption			
Saturation	0.50	%	ASTM D570
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.10	%	ASTM D570, ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	9400	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	140	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	8000	MPa	ASTM D790, ISO 178
Flexural Strength	170	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C	9.0	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 D3417
Electrical	**Nominal Value**	**Unit**	**Test Method**

Dielectric Constant (1 MHz)	3.60		IEC 60250
Comparative Tracking Index	175	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
	V-0		
1.60 mm	5VA		UL 94
	V-0		
3.00 mm	5VA		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

Recommended distributors for this material

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