

RAMSTER PF353M6

Polybutylene Terephthalate

Polyram Ram-On Industries

Message:

30% MINERAL FILLED P.B.T. FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
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)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.8	%	ASTM D955
--	1.8	%	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	58.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	4500	MPa	ASTM D790, ISO 178
Flexural Strength	110	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C	4.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	160	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	70.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	225	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Dielectric Constant (1 MHz)	3.60		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94

Glow Wire Flammability Index	650	°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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