RAMSTER PF310G6

Polybutylene Terephthalate

Polyram Ram-On Industries

Message:

30% GLASS FIBER REINFORCED P.B.T. ALLOY, LOW WARP PROPERTIES, UV STABILIZED FOR INJECTION MOULDING APPLICATIONS.

General Information			
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	1.53	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.15 - 0.75	%	ASTM D955
--	0.15 - 0.75	%	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	9100	MPa	ASTM D638, ISO 527-2
Tensile Stress (Yield)	140	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	8800	MPa	ASTM D790, ISO 178
Flexural Strength	200	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C	10	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	225	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	215	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	200	°C	
Maximum Continuous Use Temperature	130	°C	
Flammability	15	mm/min	FMVSS 302
Melting Temperature	225	°C	ISO 11357-3, ASTM D3417

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+17	ohms·cm	IEC 60093
Dielectric Strength	3.8	kV/mm	IEC 60243-1
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94
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

Susheng Import & Export Trading Co.,Ltd.

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