

RAMTAL PM1409

Acetal (POM) Copolymer

Polyram Ram-On Industries

Message:

POLYACETAL FILLED WITH 20% PTFE FOR SLIDING PARTS, LOW FRICTION AND IMPROVED WEAR RESISTANCE OF MOULDED PARTS.

General Information			
Additive	PTFE lubricant (20%)		
Features	Low friction coefficient		
	Good wear resistance		
	Lubrication		
RoHS Compliance	RoHS compliance		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45 - 1.50	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.8 - 2.2	%	ASTM D955
--	1.8 - 2.2	%	ISO 2577
Water Absorption			
Saturation	0.22	%	ASTM D570
Saturated, 23°C	0.22	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	70		ASTM D785
R scale	70		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	45.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	20	%	ASTM D638, ISO 527-2
Flexural Modulus	1750	MPa	ASTM D790, ISO 178
Flexural Strength	65.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	55	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	155	°C	ASTM D648, ISO 75-2/B

1.8 MPa, not annealed	120	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3417
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Flammability	22	mm/min	FMVSS 302
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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