

RAMTAL PM8427

Acetal (POM) Copolymer
Polyram Ram-On Industries

Message:
IMPACT MODIFIED POLYACETAL FOR INJECTION MOULDING APPLICATIONS, MFI 9.

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.8 to 2.2	%	
--	1.8 to 2.2	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	77		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	40.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	70	%	ASTM D638, ISO 527-2
Flexural Modulus	2100	MPa	ASTM D790, ISO 178
Flexural Strength	60.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	90	J/m	ASTM D256
23°C	12	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	145	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	85.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms · cm	IEC 60093
Electric Strength	24	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	4.20		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94

Flammability	32	mm/min	FMVSS 302
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	175 to 200	°C	
Middle Temperature	180 to 205	°C	
Front Temperature	190 to 210	°C	
Mold Temperature	60.0 to 110	°C	
Injection Pressure	70.0 to 105	MPa	
Holding Pressure	35.0 to 85.0	MPa	
Back Pressure	0.350 to 0.700	MPa	
Screw Speed	60 to 90	rpm	

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