

RAMSTER PF350M3

Polybutylene Terephthalate

Polyram Ram-On Industries

Message:

15% MINERAL FILLED P.B.T. FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 15% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	20	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
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2900	MPa	ASTM D638
Tensile Strength (Yield)	55.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			
Fracture	3.5	%	ASTM D638
Fracture	15	%	ISO 527-2
Flexural Modulus	3000	MPa	ASTM D790, ISO 178
Flexural Strength	95.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	50	J/m	ASTM D256
23°C	6.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	225	°C	ISO 11357-3, ASTM D3418
Electrical	Nominal Value	Test Method	
Dielectric Constant (1 MHz)	3.60	IEC 60250	
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	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

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