

RAMTAL PM3009G4

Acetal (POM) Copolymer

Polyram Ram-On Industries

Message:

20% GLASS-FIBER REINFORCED POLYACETAL FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
190°C/2.16 kg	6.0	g/10 min	ASTM D1238
180°C/2.16 kg	6.0	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.40 - 1.0	%	ASTM D955
--	0.40 - 1.0	%	ISO 2577
Water Absorption			
Saturation	0.20	%	ASTM D570
Saturated, 23°C	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	115	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus	5000	MPa	ASTM D790, ISO 178
Flexural Strength	170	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	60	J/m	ASTM D256
23°C	6.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	165	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	160	°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+16	ohms · cm	IEC 60093
Dielectric Strength	20	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94

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

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

