

RAMTAL PMH2022

Acetal (POM) Homopolymer

Polyram Ram-On Industries

Message:

GENERAL PURPOSE POLYACETAL HOMOPOLYMER FOR INJECTION MOLDING APPLICATION,MFI 22.

General Information			
Features	General Purpose		
Uses	General Purpose		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	22	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.8 to 2.2	%	
--	1.8 to 2.2	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	MPa	ASTM D638, ISO 527-2
Tensile Strength			
Yield	74.0	MPa	ASTM D638
Yield	75.0	MPa	ISO 527-2
Tensile Elongation (Break)	35	%	ASTM D638, ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179
Notched Izod Impact (23°C)	70	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	165	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	HB	UL 94	
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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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

