

RAMTAL PM3013G4

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		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.0	g/10 min	ASTM D1238, 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)	90.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus	3200	MPa	ASTM D790, ISO 178
Flexural Strength	120	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	65	J/m	ASTM D256
23°C	6.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
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
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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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

