

RAMSHINE PV507

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

FLAME RETARDANT ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	5.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.30 - 0.50	%	ASTM D955
--	0.0 - 0.50	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	45.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	10	%	ASTM D638, ISO 527-2
Flexural Modulus	2100	MPa	ASTM D790, ISO 178
Flexural Strength	70.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	250	J/m	ASTM D256
23°C	15	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	79.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	86.0	°C	ASTM D1525, ISO 306
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-0		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 3.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	200 - 220	°C	
Middle Temperature	205 - 220	°C	
Front Temperature	220 - 250	°C	

Mold Temperature	60.0 - 90.0	°C
Injection Pressure	70.0 - 105	MPa
Holding Pressure	35.0 - 70.0	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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