

Royalite R540M

Acrylonitrile Butadiene Styrene + PVC

Spartech Plastics

Message:

Royalite R540M offers a unique ABS/PVC product that has inherent flame retardancy as well as easy processing characteristics. It provides good weatherability, excellent low temperature impact strength, outstanding chemical resistance and moldability.

General Information		
UL YellowCard	E52355-242598	E52355-242599
Features	Workability, good	
	Good formability	
	Low temperature impact resistance	
	Good chemical resistance	
	Good weather resistance	
	Flame retardancy	
Uses	Electrical/Electronic Applications	
	Outdoor application	
	Communication Equipment	
	Shell	
	Consumer goods application field	
Forms	Particle	
Processing Method	Sheet extrusion molding	
	Injection molding	

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	2.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	83		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	32.8	MPa	ASTM D638
Flexural Modulus	1900	MPa	ASTM D790
Flexural Strength	49.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	400	J/m	ASTM D256
23°C	800	J/m	ASTM D256
Dart Drop Impact			ASTM D3029

-40°C, 3.18 mm	36.2	J	ASTM D3029
23°C, 3.18 mm	36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	67.2	°C	ASTM D648
0.45 MPa, annealed, 3.18mm	78.3	°C	ASTM D648
Flammability	Nominal Value		Test Method
	V-0		

Flame Rating (2.16 mm)	5VA	UL 94
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Additional Information

Weather Rating, Grey/Black: f1

Injection	Nominal Value	Unit
Drying Temperature	71.1	°C
Drying Time	1.0	hr
Suggested Max Regrind	25	%
Rear Temperature	182 - 185	°C
Middle Temperature	188 - 191	°C
Front Temperature	191 - 193	°C
Nozzle Temperature	188 - 193	°C
Processing (Melt) Temp	207 - 213	°C
Mold Temperature	26.7 - 37.8	°C
Injection Pressure	6.89 - 10.3	MPa
Injection Rate	Slow-Moderate	
Back Pressure	0.00 - 0.517	MPa
Screw Speed	30 - 40	rpm
Clamp Tonnage	3.4 - 4.1	kN/cm ²
Cushion	3.30 - 6.35	mm

Injection instructions

Hold Pressure: 50% to 75% Injection Pressure

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