

RAMTOUGH PZ725

Polycarbonate
Polyram Ram-On Industries

Message:
UV STABILIZED AND IMPACT MODIFIED POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Impact modifier		
	UV stabilizer		
Features	Impact modification		
	Good UV resistance		
RoHS Compliance	RoHS compliance		
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) (300°C/1.2 kg)	21	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50 - 0.80	%	ASTM D955
--	0.50 - 0.80	%	ISO 2577
Water Absorption			
Saturation	0.15	%	ASTM D570
Saturated, 23°C	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2000	MPa	ASTM D638
Tensile Strength (Yield)	66.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	140	%	ASTM D638, ISO 527-2
Flexural Modulus			
--	2300	MPa	ASTM D790
--	2350	MPa	ISO 178
Flexural Strength	100	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	680	J/m	ASTM D256
23°C	70	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	137	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	145	°C	ASTM D648, ISO 75-2/A

Vicat Softening Temperature	145	°C	ASTM D1525, ISO 306
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Flammability Index	850	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	270 - 290	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	290 - 310	°C	
Processing (Melt) Temp	270 - 310	°C	
Mold Temperature	80.0 - 120	°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

