

Romiloy® 4010/02 GF 8

Acrylonitrile Butadiene Styrene + Nylon

ROMIRA GmbH

Message:

Romiloy®4010/02 GF 8 is an acrylonitrile butadiene styrene + nylon (ABS + nylon) material, and the filler is 8.0% glass fiber reinforced material. This product is available in Europe, and the processing method is injection molding. Romiloy®The main characteristics of 4010/02 GF 8 are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 8.0% filler by weight		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	14	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 - 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	43.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2550	MPa	ISO 178
Flexural Stress ² (23°C)	66.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m²	ISO 179/1eA
23°C	10	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	40	kJ/m²	ISO 179/1eU
23°C	45	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°C	ISO 75-2/A
Vicat Softening Temperature	135	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm)	HB	UL 94	
Additional Information			
The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901.The value listed as Coefficient of Linear Thermal Expansion ISO 11359-1, was tested in accordance with DIN 53752Tensile Strain @ Break, DIN EN ISO 527, 50 mm/min, 23°C: >30%			
Injection	Nominal Value	Unit	
Drying Temperature	< 80.0	°C	

Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Rear Temperature	230 - 260	°C
Middle Temperature	230 - 260	°C
Front Temperature	230 - 260	°C
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	50.0 - 90.0	°C
Injection Rate	Fast	
Back Pressure	1.00	MPa
Screw Speed	12 - 18	rpm

Injection instructions

Holding Pressure: moderate to high

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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