

RAMLLOY PZF101

Polycarbonate + ABS
Polyram Ram-On Industries

Message:
PC/PBT ALLOY FOR INJECTION MOULDING APPLICATIONS, LOW TEMPERATURE AND CHEMICAL RESISTANCE.

General Information			
Features	Good chemical resistance		
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) (250°C/5.0 kg)	18	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	3.0E-3	%	ASTM D955
--	3.0E-3	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1800	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	50.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	140	%	ASTM D638, ISO 527-2
Flexural Modulus	1700	MPa	ASTM D790, ISO 178
Flexural Strength	75.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C	550	J/m	ASTM D256
23°C	750	J/m	ASTM D256
-30°C	55	kJ/m ²	ISO 180
23°C	65	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	115	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	90.0	°C	ASTM D648, ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flammability	10	mm/min	FMVSS 302
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	4.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	230 - 240	°C	
Middle Temperature	240 - 250	°C	
Front Temperature	250 - 265	°C	

Mold Temperature	50.0 - 90.0	°C
Injection Pressure	70.0 - 100	MPa
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.350 - 0.700	MPa

Injection instructions

Fill Speed: 25 to 50 mm/secMax Circumfrential Speed: 0.3 m/s

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