

RAMLLOY PZF301G4

Polycarbonate + PBT
Polyram Ram-On Industries

Message:
20% GLASS FIBER REINFORCED, IMPACT MODIFIED PC/PBT ALLOY FOR INJECTION MOLDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (275°C/2.16 kg)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.30 - 0.50	%	ASTM D955
--	0.30 - 0.50	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6600	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	100	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus	6800	MPa	ASTM D790, ISO 178
Flexural Strength	120	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
-30°C	8.0	kJ/m ²	ISO 180
23°C	10	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	195	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	135	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Dielectric Constant (1 MHz)	3.50		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Glow Wire Flammability Index	850	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	

Drying Temperature	110	°C
Drying Time	4.0 - 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	240 - 260	°C
Middle Temperature	250 - 270	°C
Front Temperature	255 - 280	°C
Mold Temperature	70.0 - 90.0	°C
Injection Pressure	70.0 - 100	MPa
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.300 - 0.700	MPa
Screw Speed	50 - 80	rpm

Injection instructions

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

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