

Romiloy® 8150

Acrylonitrile Styrene Acrylate + PC

ROMIRA GmbH

Message:

Romiloy®8150 is an acrylonitrile-styrene-acrylate PC (ASA PC) material. This product is available in Europe and is processed by extrusion or injection molding.

Romiloy®The main features of the 8150 are:

flame retardant/rated flame

Halogen-free

Flame Retardant

General Information			
UL YellowCard	E148878-461140		
Features	Chlorine Free		
	No antimony		
	Bromine-free		
	Flame retardancy		
UL File Number	E148878		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
240°C/5.0 kg	20	g/10 min	ISO 1133
260°C/5.0 kg	35	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2600	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2500	MPa	ISO 178
Flexural Stress ² (23°C)	94.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	35	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	110	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	

Drying Temperature	60.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Processing (Melt) Temp	210 - 240	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Slow	

Injection instructions

Back Pressure: <10%Holding Pressure: LowScrew Rotation Speed: slow

Extrusion	Nominal Value	Unit
Drying Temperature	< 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	200 - 240	°C
Cylinder Zone 2 Temp.	200 - 240	°C
Cylinder Zone 3 Temp.	200 - 240	°C
Cylinder Zone 4 Temp.	200 - 240	°C
Cylinder Zone 5 Temp.	200 - 240	°C
Melt Temperature	< 250	°C

NOTE

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

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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

