RAMTOUGH PZ333G2

Polycarbonate

Polyram Ram-On Industries

Message:

10% GLASS-FIBER REINFORCED, FLAME RETARDANT POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.30	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage	0.40 - 0.60	%	ISO 2577
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	3200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			
Fracture	10	%	ASTM D638
Fracture	15	%	ISO 527-2
Flexural Modulus	3400	MPa	ASTM D790, ISO 178
Flexural Strength	120	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	90	J/m	ASTM D256
23°C	8.0	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	265	°C	ISO 75-2/B
1.8 MPa, not annealed	135	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	265	°C	ASTM D1525
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 (3.00 mm)	V-0		UL 94
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 - 107	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

Recommended distributors for this material

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