

POLYFLAM® RMMK 125

Acrylonitrile Butadiene Styrene + Nylon

A. Schulman Europe

Message:

Flame-retardant ABS/PA blend; without PBDE; high stress crack resistance

General Information				
UL YellowCard		E86615-509047		
Features		High ESCR (Stress Cracking Resistance) Flame retardancy		
UL File Number		E86615		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.30	--	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	12.0	--	cm ³ /10min	ISO 1133
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2500	940	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	52.0	29.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.0	16	%	ISO 527-2/1A/50
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	9.0	--	kJ/m ²	ISO 179/1eA
23°C	12	21	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	No Break		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	113	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	60.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature				
--	190	--	°C	ISO 306/A50
--	156	--	°C	ISO 306/B50
Ball Pressure Test (125°C)	Pass	--		IEC 60695-10-2
RTI Elec				UL 746
1.50 mm	60.0	--	°C	UL 746

3.00 mm	60.0	--	°C	UL 746
RTI Imp				UL 746
1.50 mm	60.0	--	°C	UL 746
3.00 mm	60.0	--	°C	UL 746
	60.0			
RTI (1.50 mm)	60.0	--	°C	UL 746
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	200	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				ISO 3795
1.50mm, automatic fire extinguishing	0.0	--	mm/min	ISO 3795
3.00mm, automatic fire extinguishing	0.0	--	mm/min	ISO 3795
Flame Rating				UL 94, IEC 60695-11-10, -20
1.50 mm	V-0	--		UL 94, IEC 60695-11-10, -20
3.00 mm	V-0	--		UL 94, IEC 60695-11-10, -20
2.00 mm	5VA	--		UL 94, IEC 60695-11-10, -20
Glow Wire Flammability Index				IEC 60695-2-12
0.750 mm	960	--	°C	IEC 60695-2-12
1.50 mm	960	--	°C	IEC 60695-2-12
3.00 mm	960	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature				IEC 60695-2-13
1.50 mm	750	--	°C	IEC 60695-2-13
3.00 mm	750	--	°C	IEC 60695-2-13
Oxygen Index	31	--	%	ISO 4589-2
Additional Information				
干燥				
1.)				
Not for use in food contact applications2.)				
Not for use in medical or pharmaceutical applications				
Injection	Dry	Unit		
Drying Temperature	70.0 - 80.0		°C	
Drying Time	4.0 - 6.0		hr	
Rear Temperature	230		°C	
Middle Temperature	240		°C	
Front Temperature	250		°C	
Nozzle Temperature	260		°C	

Processing (Melt) Temp	240 - 260	°C
Mold Temperature	40.0 - 80.0	°C
Injection Pressure	80.0 - 150	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	30.0 - 70.0	MPa
Back Pressure	5.00 - 10.0	MPa
Cushion	< 5.00	mm
Screw Speed		mm/sec

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