

RAMSHINE PV300G6

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

30% GLASS-FIBER REINFORCED, HEAT RESISTANCE AND MINIMAL MOULD SHRINKAGE ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
	Low shrinkage		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
220°C/10.0 kg	8.0	g/10 min	ASTM D1238
300°C/1.2 kg	8.0	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.10 - 0.20	%	ASTM D955
--	0.10 - 0.20	%	ISO 2577
Water Absorption			
Saturation	0.12	%	ASTM D570
Saturated, 23°C	0.12	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	115		ASTM D785
R scale	115		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	90.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	8000	MPa	ASTM D790, ISO 178
Flexural Strength	115	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	80	J/m	ASTM D256
23°C	8.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	101	°C	ASTM D648, ISO 75-2/A
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)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 3.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	200 - 220	°C	
Middle Temperature	205 - 220	°C	
Front Temperature	220 - 250	°C	
Mold Temperature	60.0 - 90.0	°C	
Injection Pressure	70.0 - 105	MPa	
Holding Pressure	35.0 - 70.0	MPa	
Back Pressure	0.350 - 0.700	MPa	
Screw Speed	60 - 90	rpm	
Injection instructions			
Fill Speed: 25 to 50 mm/sec			

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