RAMTOUGH PZ320G2

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		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.28	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			
Flow	0.30 - 0.50	%	ASTM D955
--	0.30 - 0.50	%	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	85		ASTM D785
R scale	85		ISO 2039-2
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	3100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	55.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			ASTM D638, ISO 527-2
Yield	5.0	%	ASTM D638, ISO 527-2
Fracture	15	%	ASTM D638, ISO 527-2
Flexural Modulus	2800	MPa	ASTM D790, ISO 178
Flexural Strength	100	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C	10	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, not annealed	147	°C	ASTM D648, ISO 75-2/B

1.8 MPa, not annealed	139	°C	ASTM D648, ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	90.0		IEC 60250
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.60 mm	V-0		UL 94
3.00 mm	V-0		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	850	°C	IEC 60695-2-13
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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