

RAMSHINE PV1003

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

GENERAL PURPOSE ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	General		
Uses	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	30	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.40	%	ASTM D955
--	0.40	%	ISO 2577
Water Absorption			
Saturation	0.30	%	ASTM D570
Saturated, 23°C	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	119		ASTM D785
R scale	119		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	34.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	20	%	ASTM D638, ISO 527-2
Flexural Modulus	2200	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	260	J/m	ASTM D256
23°C	22	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	84.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	98.0	°C	ASTM D1525, ISO 306
Flammability	Nominal Value		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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