

# RAMSHINE PW311G4

Styrene Acrylonitrile  
Polyram Ram-On Industries

Message:  
20% GLASS FIBER REINFORCED SAN FOR INJECTION MOULDING APPLICATIONS.

| General Information                       |                                                       |                   |                      |
|-------------------------------------------|-------------------------------------------------------|-------------------|----------------------|
| Filler / Reinforcement                    | Glass fiber reinforced material, 20% filler by weight |                   |                      |
| Processing Method                         | Injection molding                                     |                   |                      |
| Physical                                  | Nominal Value                                         | Unit              | Test Method          |
| Specific Gravity                          | 1.20                                                  | g/cm <sup>3</sup> | ASTM D792, ISO 1183  |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg) | 8.0                                                   | g/10 min          | ASTM D1238, ISO 1133 |
| Molding Shrinkage                         |                                                       |                   |                      |
| Flow                                      | 0.20                                                  | %                 | ASTM D955            |
| --                                        | 0.20                                                  | %                 | ISO 2577             |
| Water Absorption                          |                                                       |                   |                      |
| Saturation                                | 0.10                                                  | %                 | ASTM D570            |
| Saturated, 23°C                           | 0.10                                                  | %                 | ISO 62               |
| Mechanical                                | Nominal Value                                         | Unit              | Test Method          |
| Tensile Modulus                           | 7000                                                  | MPa               | ASTM D638, ISO 527-2 |
| Tensile Strength (Yield)                  | 100                                                   | MPa               | ASTM D638, ISO 527-2 |
| Tensile Elongation (Break)                | 2.0                                                   | %                 | ASTM D638, ISO 527-2 |
| Flexural Modulus                          | 5200                                                  | MPa               | ASTM D790, ISO 178   |
| Flexural Strength                         | 200                                                   | MPa               | ASTM D790, ISO 178   |
| Impact                                    | Nominal Value                                         | Unit              | Test Method          |
| Notched Izod Impact                       |                                                       |                   |                      |
| 23°C                                      | 60                                                    | J/m               | ASTM D256            |
| 23°C                                      | 8.0                                                   | kJ/m <sup>2</sup> | ISO 180              |
| 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                                                   | hr                |                      |
| Rear Temperature                          | 220 - 240                                             | °C                |                      |
| Middle Temperature                        | 230 - 250                                             | °C                |                      |
| Front Temperature                         | 240 - 260                                             | °C                |                      |

|                        |               |     |
|------------------------|---------------|-----|
| Processing (Melt) Temp | 240 - 280     | °C  |
| Mold Temperature       | 50.0 - 80.0   | °C  |
| Injection Pressure     | 70.0 - 105    | MPa |
| Holding Pressure       | 35.0 - 70.0   | MPa |
| Back Pressure          | 0.340 - 0.690 | MPa |
| Screw Speed            | 60 - 90       | rpm |

#### Injection instructions

Fill Speed: 25 to 51 mm/sec

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#### Recommended distributors for this material

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