

Romiloy® 1035 04 F

Polycarbonate + ABS

ROMIRA GmbH

Message:

Romiloy® 1035 04 F is a polycarbonate acrylonitrile butadiene styrene (PC ABS) material. This product is available in Europe and is processed by extrusion or injection molding.

Romiloy® The main features of 1035 04 F are:

flame retardant/rated flame

high liquidity

General Information	
Features	High liquidity
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	28	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.20	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2100	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	100	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2000	MPa	ISO 178
Flexural Stress ² (23°C)	75.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	30	kJ/m ²	ISO 179/1eA
23°C	45	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	106	°C	ISO 75-2/A
Vicat Softening Temperature	125	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2

Flammability	Nominal Value	Test Method
Flame Rating (1.60 mm)	HB	UL 94

Additional Information

The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901. The value listed as Coefficient of Linear Thermal Expansion ISO 11359-1-2, was tested in accordance with DIN 53752.

Injection	Nominal Value	Unit
Drying Temperature	< 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Processing (Melt) Temp	240 - 270	°C
Mold Temperature	80.0	°C
Injection Rate	Moderate-Fast	
Extrusion	Nominal Value	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	210 - 250	°C
Cylinder Zone 2 Temp.	210 - 250	°C
Cylinder Zone 3 Temp.	210 - 250	°C
Cylinder Zone 4 Temp.	210 - 250	°C
Cylinder Zone 5 Temp.	210 - 250	°C
Melt Temperature	< 260	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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