

RAMLLOY PBB104

Polycarbonate + ABS

Polyram Ram-On Industries

Message:

PC/ABS ALLOY FOR INJECTION MOULDING APPLICATIONS.

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
260°C/5.0 kg	30	g/10 min	ASTM D1238
300°C/1.2 kg	30	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.40 - 0.70	%	
--	0.40 - 0.70	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	50.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 30	%	ASTM D638, ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	500	J/m	ASTM D256
23°C	30	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	120	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	100	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	116	°C	ASTM D1525, ISO 306
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	4.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	230 - 240	°C	
Middle Temperature	240 - 250	°C	
Front Temperature	250 - 265	°C	

Mold Temperature	50.0 - 90.0	°C
Injection Pressure	70.0 - 100	MPa
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.350 - 0.700	MPa

Injection instructions

Fill Speed: 25 to 50 mm/secMax Circumfrential Speed: 0.3 m/s

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