

RAMLLOY PBB101

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) (240°C/5.0 kg)	18	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.40 to 0.70	%	
--	0.40 to 0.70	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	50.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 30	%	ASTM D638, ISO 527-2
Flexural Modulus	2300	MPa	ASTM D790, ISO 178
Flexural Strength	90.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	400	J/m	ASTM D256
23°C	45	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	120	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	100	°C	ASTM D648, ISO 75-2/A
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 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	250 to 265	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	70.0 to 100	MPa	

Holding Pressure	35.0 to 70.0	MPa
Back Pressure	0.350 to 0.700	MPa

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