

Romiloy® 4010/02 GF 20

Acrylonitrile Butadiene Styrene + Nylon

ROMIRA GmbH

Message:

Romiloy® 4010/02 GF 20 is an acrylonitrile butadiene styrene + nylon (ABS + nylon) material, and the filler is 20% glass fiber reinforced material. This product is available in Europe, and the processing method is injection molding. Romiloy® The main characteristics of 4010/02 GF 20 are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	6.0	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3600	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	56.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	4.9	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	3020	MPa	ISO 178
Flexural Stress ² (23°C)	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	30	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	150	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	< 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
Suggested Max Regrind	5	%	
Rear Temperature	230 - 260	°C	
Middle Temperature	230 - 260	°C	
Front Temperature	230 - 260	°C	
Processing (Melt) Temp	250 - 270	°C	
Mold Temperature	50.0 - 90.0	°C	
Injection Rate	Fast		
Back Pressure	1.00	MPa	
Screw Speed	12 - 18	rpm	

Injection instructions

Holding Pressure: moderate to high

NOTE

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| 1. | 2.0 mm/min |
| 2. | 2.0 mm/min |

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