

RAMSHINE PV527

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

FLAME RETARDANT ABS FOR INJECTION MOULDING APPLICATIONS

General Information			
UL YellowCard	E174094-100164024		
Additive	Flame retardancy		
Features	Flame retardancy		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	55 - 60	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.30 - 0.50	%	ASTM D955
--	0.30 - 0.50	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	45.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	2500	MPa	ASTM D790, ISO 178
Flexural Strength	75.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	95	J/m	ASTM D256
23°C	9.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	86.0	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	79.0	°C	ASTM D648, ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-0		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	700	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 - 3.0	hr	

Suggested Max Moisture	0.050	%
Rear Temperature	200 - 220	°C
Middle Temperature	205 - 220	°C
Front Temperature	220 - 250	°C
Mold Temperature	60.0 - 90.0	°C
Injection Pressure	70.0 - 105	MPa
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.350 - 0.700	MPa
Screw Speed	60 - 90	rpm

Injection instructions

Fill Speed: 25 to 50 mm/sec

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

