

RAMSHINE PV504GR

Acrylonitrile Butadiene Styrene
Polyram Ram-On Industries

Message:
FLAME RETARDANT, UV STABILIZED ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	UV stabilizer		
	Flame retardancy		
Features	Good UV resistance		
	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) (200°C/5.0 kg)	3.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow	0.30 - 0.60	%	ASTM D955
Water Absorption (Saturation, 23°C)	0.30 - 0.60	%	ISO 62
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)	9.0	%	ASTM D638, ISO 527-2
Flexural Modulus	2300	MPa	ASTM D790, ISO 178
Flexural Strength	80.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	200	J/m	ASTM D256
23°C	16	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	80.0	°C	ASTM D648, ISO 75-2/A
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	V-0	UL 94	
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

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