

RAMLLOY PBB503

Polycarbonate + ABS
Polyram Ram-On Industries

Message:
FLAME RETARDANTS AND HEAT STABILIZED PC/ABS ALLOY FOR INJECTION MOLDING APPLICATIONS.

General Information			
Additive	Flame Retardant		
	Heat Stabilizer		
Features	Flame Retardant		
	Heat Stabilized		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/5.0 kg)	30	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 Modulus	2700	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 30	%	ASTM D638, ISO 527-2
Flexural Modulus	2500	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	700	J/m	ASTM D256
23°C	50	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	95.0	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	85.0	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Electric Strength	30	kV/mm	IEC 60250
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
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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