

RAMTOUGH RZ310G6

Polycarbonate
Polyram Ram-On Industries

Message:
30% GLASS-FIBER REINFORCED POLYCARBONTE FOR INJECTION MUOLDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	3.5	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.20 - 0.30	%	ASTM D955
--	0.20 - 0.30	%	ISO 2577
Water Absorption			
Saturation	0.070	%	ASTM D570
Saturated, 23°C	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	120	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.0	%	ASTM D638, ISO 527-2
Flexural Modulus	7000	MPa	ASTM D790, ISO 178
Flexural Strength	195	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C	13	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	147	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	139	°C	ASTM D648, ISO 75-2/A
Thermal Conductivity	0.24	W/m/K	ASTM C177, DIN 52612
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms · cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.30		IEC 60250
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-1		UL 94
Injection	Nominal Value	Unit	

Drying Temperature	120	°C
Drying Time	4.0 - 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	270 - 290	°C
Middle Temperature	280 - 300	°C
Front Temperature	290 - 310	°C
Processing (Melt) Temp	270 - 310	°C
Mold Temperature	80.0 - 120	°C
Injection Pressure	70.0 - 107	MPa
Holding Pressure	35.0 - 85.0	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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