

RAMSHINE PW300G7

Styrene Acrylonitrile
Polyram Ram-On Industries

Message:
35% Glass Fiber reinforced SAN for very high rigidity injection molding applications

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Features	Rigidity, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	9.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.20	%	ASTM D955
--	0.20	%	ISO 2577
Water Absorption			
Saturation	0.10	%	ASTM D570
Saturated, 23°C	0.10	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	94		ASTM D785
R scale	94		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	110	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	1.5	%	ASTM D638, ISO 527-2
Flexural Modulus	10000	MPa	ASTM D790, ISO 178
Flexural Strength	160	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	65	J/m	ASTM D256
23°C	6.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	110	°C	ASTM D648, ISO 75-2/A
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	40	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.10		IEC 60250

Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Rear Temperature	220 - 240	°C
Middle Temperature	230 - 250	°C
Front Temperature	240 - 260	°C
Processing (Melt) Temp	240 - 280	°C
Mold Temperature	50.0 - 80.0	°C
Injection Pressure	70.0 - 105	MPa
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.340 - 0.690	MPa
Screw Speed	60 - 90	rpm

Injection instructions
Fill Speed: 25 to 51 mm/sec

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Recommended distributors for this material

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