

RAMTOUGH RZ224

Polycarbonate
Polyram Ram-On Industries

Message:
POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
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) (300°C/1.2 kg)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50 - 0.70	%	ASTM D955
--	0.50 - 0.70	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	> 60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 95	%	ASTM D638, ISO 527-2
Flexural Modulus	> 2200	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	No Break		ASTM D256
23°C	> 65	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	> 130	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	> 120	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	145	°C	ASTM D1525, ISO 306
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-2		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
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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