

Romiloy® 6020 F

Acrylonitrile Styrene Acrylate + PC

ROMIRA GmbH

Message:

Romiloy® 6020 F is an acrylonitrile-styrene-acrylate PC (ASA PC) material. This product is available in Europe and is processed by extrusion or injection molding.

Romiloy® The main features of 6020 F are:

flame retardant/rated flame

high liquidity

General Information	
Features	High liquidity
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	50	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.30 - 0.60	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	70	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2300	MPa	ISO 178
Flexural Stress ² (23°C)	93.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	40	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	104	°C	ISO 75-2/A
Vicat Softening Temperature	126	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2

Flammability	Nominal Value	Test Method
Flame Rating (1.60 mm)	HB	UL 94

Additional Information	
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The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901. The value listed as Coefficient of Linear Thermal Expansion ISO 11359-1-2, was tested in accordance with DIN 53752.

Injection	Nominal Value	Unit
Drying Temperature	60.0 - 100	°C

Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	60.0 - 100	°C
Injection Rate	Moderate	

Injection instructions

Back Pressure: <20% Holding Pressure: Low

Extrusion	Nominal Value	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	210 - 250	°C
Cylinder Zone 2 Temp.	210 - 250	°C
Cylinder Zone 3 Temp.	210 - 250	°C
Cylinder Zone 4 Temp.	210 - 250	°C
Cylinder Zone 5 Temp.	210 - 250	°C
Melt Temperature	< 260	°C

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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