

RAMTOUGH RZ720

Polycarbonate

Polyram Ram-On Industries

Message:

UV STABILIZED AND IMPACT MODIFIED POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Impact modifier		
	UV stabilizer		
Features	Impact modification		
	Good UV resistance		
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
--	> 220	MPa	ISO 178
Flexural Strength	> 90.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	600	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, 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	750	°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

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

