

# Romiloy® 1055

Polycarbonate + ABS

ROMIRA GmbH

## Message:

Romiloy® 1055 is a polycarbonate acrylonitrile butadiene styrene (PC ABS) material. This product is available in Europe and is processed by extrusion or injection molding. Romiloy® The main characteristics of the 1055 are: flame retardant/rated flame.

| General Information                                                                                                                                                                                       |                   |                   |              |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|-------------------|--------------|
| Forms                                                                                                                                                                                                     | Particle          |                   |              |
| Processing Method                                                                                                                                                                                         | Extrusion         |                   |              |
|                                                                                                                                                                                                           | Injection molding |                   |              |
| Physical                                                                                                                                                                                                  | Nominal Value     | Unit              | Test Method  |
| Density                                                                                                                                                                                                   | 1.09              | g/cm <sup>3</sup> | ISO 1183     |
| Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)                                                                                                                                                                  | 15                | g/10 min          | ISO 1133     |
| Molding Shrinkage (23°C)                                                                                                                                                                                  | 0.40 - 0.70       | %                 | ISO 294-4    |
| Water Absorption (23°C, 24 hr)                                                                                                                                                                            | 0.20              | %                 | ISO 62       |
| Mechanical                                                                                                                                                                                                | Nominal Value     | Unit              | Test Method  |
| Tensile Modulus (23°C)                                                                                                                                                                                    | 2400              | MPa               | ISO 527-2/1  |
| Tensile Stress (Yield, 23°C)                                                                                                                                                                              | 54.0              | MPa               | ISO 527-2/50 |
| Tensile Strain (Break, 23°C)                                                                                                                                                                              | 35                | %                 | ISO 527-2/50 |
| Flexural Modulus <sup>1</sup> (23°C)                                                                                                                                                                      | 2250              | MPa               | ISO 178      |
| Flexural Stress <sup>2</sup> (23°C)                                                                                                                                                                       | 85.0              | MPa               | ISO 178      |
| Impact                                                                                                                                                                                                    | Nominal Value     | Unit              | Test Method  |
| Charpy Notched Impact Strength (23°C)                                                                                                                                                                     | 34                | kJ/m <sup>2</sup> | 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)                                                                                                                                                         | 95.0              | °C                | ISO 75-2/A   |
| Vicat Softening Temperature                                                                                                                                                                               | 110               | °C                | ISO 306/B50  |
| CLTE - Flow (23 to 55°C)                                                                                                                                                                                  | 9.0E-5            | cm/cm/°C          | ISO 11359-2  |
| Flammability                                                                                                                                                                                              | Nominal Value     |                   | Test Method  |
| Flame Rating (1.60 mm)                                                                                                                                                                                    | HB                |                   | UL 94        |
| Additional Information                                                                                                                                                                                    |                   |                   |              |
| 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, was tested in accordance with DIN 53752. |                   |                   |              |
| Injection                                                                                                                                                                                                 | Nominal Value     | Unit              |              |
| Drying Temperature                                                                                                                                                                                        | < 80.0            | °C                |              |
| Drying Time                                                                                                                                                                                               | 2.0 - 4.0         | hr                |              |
| Suggested Max Moisture                                                                                                                                                                                    | 0.050             | %                 |              |
| Suggested Max Regrind                                                                                                                                                                                     | 5                 | %                 |              |

| Processing (Melt) Temp | 240 - 270     | °C   |
|------------------------|---------------|------|
| Mold Temperature       | 80.0          | °C   |
| Injection Rate         | Moderate-Fast |      |
| 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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