

RAMTOUGH PZ509

Polycarbonate
Polyram Ram-On Industries

Message:
NON TRANSPARENT POLYCARBONATE EASY FLOW FLAME RETARDANT FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame retardancy		
Features	Flame retardancy		
RoHS Compliance	RoHS compliance		
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)	20	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50 - 0.90	%	ASTM D955
--	0.50 - 0.90	%	ISO 2577
Water Absorption			
Saturation	0.12	%	ASTM D570
Saturated, 23°C	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2130	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	65.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	120	%	ASTM D638, ISO 527-2
Flexural Modulus	2190	MPa	ASTM D790, ISO 178
Flexural Strength	100	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	700	J/m	ASTM D256
23°C	17	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	140	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	130	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+19	ohms · cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.00		IEC 60250
Comparative Tracking Index	50.0	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method

Flame Rating		UL 94
1.60 mm	V-0	UL 94
3.00 mm	V-0	UL 94

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 - 105	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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