

RAMTOUGH PZ301R8

Polycarbonate
Polyram Ram-On Industries

Message:
40% CARBON-FIBER REINFORCED POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 40% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	5.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.20 - 0.30	%	ASTM D955
--	0.20 - 0.30	%	ISO 2577
Water Absorption			
Saturation	0.070	%	ASTM D570
Saturated, 23°C	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	19500	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	135	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	1.5	%	ASTM D638, ISO 527-2
Flexural Modulus	13500	MPa	ASTM D790, ISO 178
Flexural Strength	185	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	55	J/m	ASTM D256
23°C	5.5	kJ/m ²	ISO 180
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	30	ohms	IEC 60093
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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