

RAMSHINE PV701

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

UV STABILIZED ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	22	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.40	%	ASTM D955
--	0.40	%	ISO 2577
Water Absorption			
Saturation	0.30	%	ASTM D570
Saturated, 23°C	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2150	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	45.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	35	%	ASTM D638, ISO 527-2
Flexural Modulus			
--	2000	MPa	ASTM D790
--	200	MPa	ISO 178
Flexural Strength	65.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	300	J/m	ASTM D256
23°C	25	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	84.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	98.0	°C	ASTM D1525, ISO 306
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	

Drying Time	2.0 - 3.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	200 - 220	°C
Middle Temperature	205 - 220	°C
Front Temperature	220 - 250	°C
Mold Temperature	60.0 - 90.0	°C
Injection Pressure	70.0 - 105	MPa
Holding Pressure	35.0 - 70.0	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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