

RAMTOUGH PZ741

Polycarbonate
Polyram Ram-On Industries

Message:
UV STABILIZED LOW VISCOSITY POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	UV Stabilizer		
Features	Good UV Resistance		
	Low Viscosity		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50 to 0.80	%	
--	0.50 to 0.80	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	65.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	100	%	ASTM D638, ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C	500	J/m	ASTM D256
23°C	700	J/m	ASTM D256
-30°C	10	kJ/m ²	ISO 180
23°C	13	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	137	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	128	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms · cm	IEC 60093
Electric Strength	30	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-2		UL 94

Glow Wire Flammability Index (3.00 mm) 850 °C IEC 60695-2-12

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	270 to 290	°C
Middle Temperature	280 to 300	°C
Front Temperature	290 to 310	°C
Processing (Melt) Temp	270 to 310	°C
Mold Temperature	80.0 to 120	°C
Injection Pressure	70.0 to 105	MPa
Holding Pressure	35.0 to 85.0	MPa
Back Pressure	0.350 to 0.700	MPa
Screw Speed	60 to 90	rpm

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