RAMSHINE PV3003R2

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

10% CARBON FIBER REINFORCED ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.10	g/cm³	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	0.10 - 0.30	%	ASTM D955
--	0.10 - 0.30	%	ISO 2577
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	5000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	80.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus	6000	MPa	ASTM D790, ISO 178
Flexural Strength	110	MPa	ASTM D790, ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	70	J/m	ASTM D256
23°C	5.0	kJ/m²	ISO 180
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+5	ohms·cm	IEC 60093
Flammability	**Nominal Value**	**Unit**	**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

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China