

RAMLLOY PI300G6

Polyvinylidene Fluoride

Polyram Ram-On Industries

Message:

30% GLASS-FIBER REINFORCED, HIGH THERMAL RESISTANCE, HIGH UV AND RADIATION PVDF FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good UV resistance		
	Heat resistance, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.95	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/5.0 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30	%	ASTM D955
Water Absorption (Saturation)	> 0.040	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1100	MPa	ASTM D638
Tensile Strength (Yield)	58.0	MPa	ASTM D638
Tensile Elongation (Break)	1.2	%	ASTM D638
Flexural Modulus	6300	MPa	ASTM D790
Flexural Strength	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	170	°C	ASTM D648, ISO 75-2/A
Peak Melting Temperature	175	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0	hr	
Rear Temperature	180 - 200	°C	
Middle Temperature	180 - 200	°C	
Front Temperature	180 - 200	°C	
Processing (Melt) Temp	180 - 200	°C	
Mold Temperature	80.0 - 100	°C	
Injection Pressure	60.0 - 100	MPa	
Holding Pressure	30.0 - 70.0	MPa	
Back Pressure	0.300 - 0.600	MPa	

Screw Speed	60 - 90	rpm
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Injection instructions

Fill Speed: 13 to 25 mm/sec

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Recommended distributors for this material

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