

RAMTOUGH PZ780

Polycarbonate

Polyram Ram-On Industries

Message:

GENERAL PORPOSE , UV STABILIZED POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
	General		
Uses	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50 - 0.80	%	ASTM D955
--	0.50 - 0.80	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	70.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation			
Fracture	60	%	ASTM D638
Fracture	65	%	ISO 527-2
Flexural Modulus	2350	MPa	ASTM D790, ISO 178
Flexural Strength	98.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	750	J/m	ASTM D256
23°C	85	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	137	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	124	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	145	°C	ASTM D1525, ISO 306
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method

Flame Rating (3.00 mm)	V-2	UL 94
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 - 105	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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