

RAMSHINE PV300G4

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

20% GLASS-FIBER REINFORCED, HEAT RESISTANCE AND MINIMAL MOULD SHRINKAGE ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Low shrinkage		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20	%	ASTM D955
Water Absorption (Saturation)	0.14	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	70.0	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	5000	MPa	ASTM D790
Flexural Strength	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	90	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	100	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	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

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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

