

RAMLLOY PBB520

Polycarbonate + ABS
Polyram Ram-On Industries

Message:
FLAME RETARDANT PC/ABS ALLOY FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	45	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-2
Tensile Stress (Yield)	50.0	MPa	ISO 527-2
Tensile Strain (Break)	> 30	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	35	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	95.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	85.0	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	250 to 265	°C	
Mold Temperature	50.0 to 90.0	°C	
Injection Pressure	70.0 to 100	MPa	
Holding Pressure	35.0 to 70.0	MPa	
Back Pressure	0.350 to 0.700	MPa	

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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

