

RAMSHINE PV801

Acrylonitrile Butadiene Styrene

Polyram Ram-On Industries

Message:

IMPACT MODIFIED ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.50	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	101		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	47.0	MPa	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Flexural Modulus	2300	MPa	ASTM D790
Flexural Strength	74.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	91.0	°C	ASTM D648
Vicat Softening Temperature	98.0	°C	ASTM D1525
Flammability	Nominal Value		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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