

Romiloy® 2720

Polycarbonate + PET

ROMIRA GmbH

Message:

Romiloy® 2720 is a polycarbonate PET (PC PET) material. This product is available in Europe, and the processing method is injection molding.

Romiloy® The main features of the 2720 are:

flame retardant/rated flame

Heat resistance

General Information			
Features	Heat resistance, high		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	30	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 - 0.60	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2340	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	100	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2350	MPa	ISO 178
Flexural Stress ² (23°C)	92.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	19	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	128	°C	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (3.00 mm)	750	°C	IEC 60695-2-12
Additional Information			
The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901. Tensile Strain at Break, ISO 527, 23°C, 50 mm/min: >100%			
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	

Suggested Max Regrind	5	%
Rear Temperature	260 - 290	°C
Middle Temperature	260 - 290	°C
Front Temperature	260 - 290	°C
Processing (Melt) Temp	< 300	°C
Mold Temperature	60.0 - 90.0	°C
Injection Rate	Moderate	
Back Pressure	< 1.00	MPa
Screw Speed	12 - 18	rpm

Injection instructions

Holding Pressure: moderate to high

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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