

RAMTOUGH RZ300G4

Polycarbonate
Polyram Ram-On Industries

Message:
20% GLASS-FIBER REINFORCED POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
300°C/1.2 kg	10	g/10 min	ASTM D1238
300°C/1.2 kg	8.0	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.20	%	ASTM D955
--	0.20	%	ISO 2577
Water Absorption			
Saturation	0.12	%	ASTM D570
Saturated, 23°C	0.29	%	ISO 62
Equilibrium, 23°C, 50% RH	0.29	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	100	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	4800	MPa	ASTM D790, ISO 178
Flexural Strength	160	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	170	J/m	ASTM D256
23°C	17	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	140	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	135	°C	ASTM D648, ISO 75-2/A
Thermal Conductivity	0.22	W/m/K	ASTM C177, DIN 52612
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms · cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	3.20		IEC 60250

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 - 107	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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