

Romiloy® 5030 GF 20

Acrylonitrile Butadiene Styrene + PBT

ROMIRA GmbH

Message:

Romiloy® 5030 GF 20 is an acrylonitrile butadiene styrene + PBT (ABS + PBT) material, and the filler is 20% glass fiber reinforced material. This product is available in Europe, and the processing method is injection molding. Romiloy® The main characteristics of 5030 GF 20 are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.29	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	30	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.30 - 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6600	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	95.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	4.8	%	ISO 527-2/5
Flexural Modulus ¹ (23°C)	6300	MPa	ISO 178
Flexural Stress ² (23°C)	145	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength (23°C)	25	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	108	°C	ISO 75-2/A
Vicat Softening Temperature	125	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Additional Information			
The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with DIN 16901.			
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	240 - 260	°C	
Middle Temperature	240 - 260	°C	
Front Temperature	240 - 260	°C	
Processing (Melt) Temp	< 260	°C	
Mold Temperature	50.0 - 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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