

RAMTOUGH PZ500

Polycarbonate

Polyram Ram-On Industries

Message:

FLAME RETARDANT POLYCARBONATE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50 - 0.80	%	ASTM D955
--	0.50 - 0.80	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	63.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	95	%	ASTM D638, ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	250	J/m	ASTM D256
23°C	20	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	135	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	125	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+18	ohms · cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	V-0		UL 94
Glow Wire Flammability Index	850	°C	IEC 60695-2-12
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 - 105	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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