

RAMSHINE PV102

Acrylonitrile Butadiene Styrene
Polyram Ram-On Industries

Message:
GENERAL PURPOSE ABS FOR INJECTION MOULDING APPLICATIONS.

General Information			
Features	General		
Uses	General		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	18	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.50	%	ASTM D955
--	0.50	%	ISO 2577
Water Absorption			
Saturation	1.0	%	ASTM D570
Saturated, 23°C	1.0	%	ISO 62
Equilibrium, 23°C, 50% RH	0.22	%	ASTM D570, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	40.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	10	%	ASTM D638, ISO 527-2
Flexural Modulus	3000	MPa	ASTM D790, ISO 178
Flexural Strength	65.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	280	J/m	ASTM D256
23°C	280	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	105	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	100	°C	ASTM D648, ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	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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