

RAMSHINE PW310G13

Styrene Acrylonitrile
Polyram Ram-On Industries

Message:
13% Glass Fiber reinforced SAN for low warpage and high rigidity injection molding applications

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 13% filler by weight		
Features	Low warpage		
	Rigidity, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20	%	ASTM D955
Water Absorption (Saturation)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	90.0	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	5000	MPa	ASTM D790
Flexural Strength	140	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	75	J/m	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	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	hr	
Rear Temperature	220 - 240	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	240 - 260	°C	
Processing (Melt) Temp	240 - 280	°C	
Mold Temperature	50.0 - 80.0	°C	
Injection Pressure	70.0 - 105	MPa	
Holding Pressure	35.0 - 70.0	MPa	
Back Pressure	0.340 - 0.690	MPa	
Screw Speed	60 - 90	rpm	

Injection instructions

Fill Speed: 25 to 51 mm/sec

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

