

Romiloy® 1035

Polycarbonate + ABS

ROMIRA GmbH

Message:

Romiloy® 1035 is a Polycarbonate + ABS (PC+ABS) material. It is available in Europe for injection molding. Primary attribute of Romiloy® 1035: Flame Rated.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/3.8 kg)	15	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2200	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	55.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	130	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	2000	MPa	ISO 178
Flexural Stress ² (23°C)	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	42	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	101	°C	ISO 75-2/A
Vicat Softening Temperature	128	°C	ISO 306/B50
CLTE - Flow (23 to 55°C)	8.5E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	< 100	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Suggested Max Regrind	5	%	
Processing (Melt) Temp	240 to 270	°C	
Mold Temperature	80.0	°C	
Injection Rate	Moderate-Fast		
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	

Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	210 to 250	°C
Cylinder Zone 2 Temp.	210 to 250	°C
Cylinder Zone 3 Temp.	210 to 250	°C
Cylinder Zone 4 Temp.	210 to 250	°C
Cylinder Zone 5 Temp.	210 to 250	°C
Melt Temperature	< 260	°C

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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Recommended distributors for this material

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