

Romiloy® 4010

Acrylonitrile Butadiene Styrene + Nylon

ROMIRA GmbH

Message:

Romiloy® 4010 is an acrylonitrile butadiene styrene nylon (ABS nylon) material. This product is available in Europe, and the processing method is injection molding.

Romiloy® The main features of the 4010 are:

flame retardant/rated flame

Impact resistance

General Information			
Features	Impact resistance, high		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	20	g/10 min	ISO 1133
Molding Shrinkage (23°C)	1.0 - 1.4	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1750	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	42.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	200	%	ISO 527-2/50
Flexural Modulus ¹ (23°C)	1500	MPa	ISO 178
Flexural Stress ² (23°C)	58.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	25	kJ/m ²	ISO 179/1eA
23°C	85	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	140	°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. Tensile Strain @ Break, DIN EN ISO 527, 50 mm/min, 23°C: >200%			
Injection	Nominal Value	Unit	
Drying Temperature	< 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	

Suggested Max Regrind	5	%
Rear Temperature	230 - 250	°C
Middle Temperature	230 - 250	°C
Front Temperature	230 - 250	°C
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	50.0 - 90.0	°C
Injection Rate	Fast	
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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