

**RamShine PV100GR435**

ABS

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	<b>18</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
<b>Other Standards<sup>[S]</sup></b>			
Molding shrinkage, parallel	<b>0.6</b>	%	Producer Method

S: These properties are reported by the producer according standards that are different to our defaults.

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Izod notched impact strength, +23°C	<b>25</b>	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Izod Impact notched, 1/8 in	<b>300</b>	J/m	ASTM D 256

Other properties	Value	Unit	Test Standard
Density	<b>1050</b>	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.1</b>	%	-
Mold temperature	<b>40 - 80</b>	°C	-
Feed temperature	<b>60 - 70</b>	°C	-
Zone 1	<b>200 - 220</b>	°C	-
Zone 2	<b>200 - 220</b>	°C	-
Zone 3	<b>210 - 240</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Certifications**

Food contact, Food approval 10/2011

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa