

RamShine PJ712BL215A

(ASA+ABS)

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	17	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	0.4	%	Producer Method

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

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Izod notched impact strength, +23°C	35	kJ/m ²	ISO 180/1A

Other properties	Value	Unit	Test Standard
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1070	kg/m ³	ISO 1183

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

Characteristics**Processing**

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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