

RamLloy PBB503GR185-1

(PC+ABS)

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	24	g/10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	55	MPa	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
ASTM Data			
Izod Impact notched, 1/8 in	630	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Burning behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	3.0	mm	-

Other properties	Value	Unit	Test Standard
Water absorption	0.8	%	Sim. to ISO 62
Humidity absorption	0.4	%	Sim. to ISO 62
Density	1170	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	≤0.02	%	-
Mold temperature	50 - 90	°C	-
Feed temperature	60 - 70	°C	-
Zone 1	220 - 240	°C	-
Zone 2	230 - 240	°C	-
Zone 3	230 - 245	°C	-

Characteristics**Processing**

Injection Molding

Certifications

RoHS compliant

Additives

Flame retarding agent

Regional Availability

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

Special Characteristics

Flame retardant