

**RamLloy PBB510WT121**

(PC+ABS)

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	240	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2700	MPa	ISO 527
Tensile Strength	60	MPa	ISO 527
Yield stress	3.5	MPa	ISO 527
Yield strain	3.7	%	ISO 527
Izod notched impact strength, +23°C	45	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	10	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
<b>ASTM Data</b>			
Izod Impact notched, 1/8 in	740	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	92	°C	ISO 75-1/-2
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	0.5	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1180	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 5	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

**Delivery form**

White

**Additives**

Flame retarding agent

**Special Characteristics**

Flame retardant

**Certifications**

RoHS compliant

**Regional Availability**

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