

RamShine PJ702GR421

(ASA+ABS)

Polyram

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Other Standards^[S]			
Molding shrinkage, parallel	0.6	%	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			
Tensile Modulus	2000	MPa	ISO 527
Tensile Strength	40	MPa	ISO 527
Yield strain	2.7	%	ISO 527
Izod notched impact strength, +23°C	30	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

Certifications

RoHS compliant

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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