

RamShine PJ712BK11

(ASA+ABS)

Polyram

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--------------------------------------|-------|---------|-----------------|
| ISO Data | | | |
| Melt flow index, MFI | 16 | 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 | | | |
| Izod notched impact strength, +23°C | 30 | kJ/m ² | ISO 180/1A |
| Other properties | | | |
| 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

Delivery form

Black

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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