

Product Texts

PC/ABS low gloss.

Processing/Physical Characteristics

	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	17	g/10min	ASTM D 1238
Temperature	260	°C	-
Load	5	kg	-

Mechanical properties

	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	54	MPa	ASTM D 638
Elongation at Break	75	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	534	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	320	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties

	Value	Unit	Test Standard
ISO Data			
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
ASTM Data			
DTUL @ 66 psi	129	°C	ASTM D 648
DTUL @ 264 psi	107	°C	ASTM D 648
Vicat Temperature	129	°C	ASTM D 1525
Thermal Conductivity, solid state	0.2	W/(m K)	ASTM C 177

Other properties

	Value	Unit	Test Standard
Water Absorption, 24hr	0.1	%	ASTM D 570
Water Absorption, Equilibrium	0.4	%	ASTM D 570
Density	1130	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
Pre-drying - Temperature	105 - 110	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	275 - 300	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	250 - 290	°C	-
Zone 2	255 - 295	°C	-
Zone 3	260 - 300	°C	-
Nozzle temperature	275 - 300	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-