

PC/ABS compound

Application: Technical injection molded parts

Typical values	Condition	Unit	Test method	Values
Rheological properties				
MVR	260°C / 5 kg	cm ³ /10 min	ISO 1133	23
Mechanical properties				
Charpy unnotched impact strength	23 °C	kJ/m ²	ISO 179/1eU	no break
Charpy unnotched impact strength	- 30 °C	kJ/m ²	ISO 179/1eU	no break
Charpy notched impact strength	23 °C	kJ/m ²	ISO 179/1eA	38
Charpy notched impact strength	- 30 °C	kJ/m ²	ISO 179/1eA	25
Tensile modulus	1 mm / min	MPa	ISO 527-1	2.400
Yield Stress	50 mm / min	MPa	ISO 527-1	55
Yield Strain	50 mm / min	%	ISO 527-1	5,5
Flexural Modulus	2 mm / min	MPa	ISO 178	2.300
Flexural Strength	2 mm / min	MPa	ISO 178	80
3,5 % Flexural Stress	2 mm / min	MPa	ISO 178	74
Thermal properties				
Vicat Softening temperature	50°C / 50 N	°C	ISO 306	128
Heat deflection temperature HDT A	1,8 MPa	°C	ISO 75-2	109
Heat deflection temperature HDT B	0,45 MPa	°C	ISO 75-2	128
Other properties				
Density	23 °C	g/cm ³	ISO 1183	1,15
Shrinkage		%		0,45 – 0,8

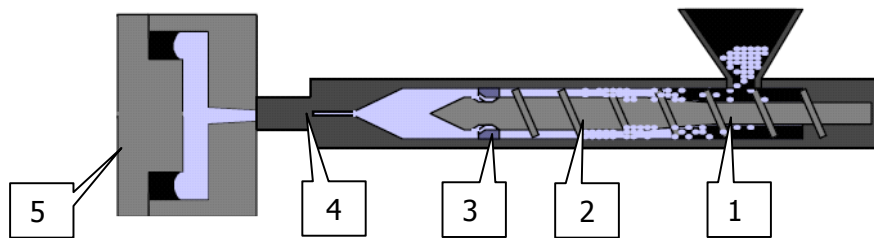
Processing recommendations:

Drying

Drying temperature in °C	Drying time (h) Dry air dryer
80-100	2-4

- Residual moisture content max 0,05 %
- When downtime of 4 hours, we recommend lowering the temperature of the dryer by 40 ° C.

Processing recommendations



Melt temperature (°C)	5. Mold (°C)	4. Nozzle (°C)	3. Zone (°C)	2. Zone (°C)	1. Zone (°C)
240 - 270	70-100	240-270	240-270	240-260	230-250

- Shrinkage according to Literature: 0,45 to 0,8% (depending on the part geometry and the process)
- Setting may be different depending on the part design and machine type of recommended values.

Test Values

The stated values were – if not otherwise stated – taken on standardized test specimen at room ambient temperature. The specifications have to be regarded as guidance values, but not as binding minimum values. Please note that the properties can be considerably influenced by mould design, processing parameters and coloring.

Processing Instructions

When processing on the basis of the recommended processing parameters, small quantities of dissociation products can emit. According to the safety data sheet, the workplace exposure limit has to be kept by means of adequate exhaustion and ventilation, in order not to affect the machine operators' health and well-being. The compulsory processing temperatures must not be considerably exceeded, in order to avoid a stronger partial decomposition of the polymers and dissociation of volatile decomposition products.

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