



TECHNICAL DATASHEET

DIJBLEND 1000 D25 HF

PC / ABS Compound | Colour: Black

Property	Method	Measurement condition	Unit	Values
Melt flow rate	ISO 1133	260 °C/5 kg	g/10 min	35
Izod Impact Strength at 23 °C	ISO 180	Notched	kJ/m ²	28
Tensile strength	ISO 527-1	10 mm/min	MPa	44
E-modulus	ISO 527-1	10 mm/min	GPa	2,2
Heat deflection temperature	ISO 75A	A	°C	122
Shore hardness	ISO 868	D		69
Density	ISO 1183-1	Method A	g/cm ³	1,18
Moldshrinkage	Inhouse method		%	0,6

Application data

Description	PC/ABS Compound with good flow
Application	Injection Moulding
Drying conditions	90 °C , 6 - 8 hours moisture content < 0,02%
Moulding temperature - Nozzle	250 - 270 °C
Moulding temperature - Barrel	240 - 280 °C
Mold Temperature	60 - 100 °C
Compression ratio	2:1 - 2,5:1
Injection Pressure	Low to medium
Injection Speed	Fast ram speed
Hold pressure	Low to medium
Screw speed	0,05 - 0,2 m/s
Cushion	4 - 6 mm
Back pressure	0 - 1,0 MPa

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