



## TECHNICAL DATASHEET

# DIJBLEND 240 FR V0

PC/ABS compound, injection molding type | High flow, flame retardant Halogen Free

Property	Method	Measurement condition	Unit	Values
Melt Volume rate	ISO 1133	240°C/5 kg	cm <sup>3</sup> /10 min	24
Density	ISO 1183	-	kg/m <sup>3</sup>	1180
Tensile modulus	ISO 527-1	1mm/min	MPa	2600
Yield stress (at break)	ISO 527-2	5mm/min	MPa	54
Flexural modulus	ISO 178	-	MPa	2500
Izod Impact at 23 °C	ISO 180/1U	unnotched	KJ/m <sup>2</sup>	NB
Izod Impact at 23 °C	ISO 180/1A	notched	KJ/m <sup>2</sup>	40
Heat Deflection Temperature	ISO 75-2	1.8 MPa	°C	82
Heat Deflection Temperature	ISO 75-2	0.45 MPa	°C	92
Vicat Softening Point	ISO 306	RateB/50	°C	97
Flammability	UL 94(in house method)	V-0	MM	1.6

### Application data

Description	PC/ABS Flame-retardend Compound with good flow
Application	Injection Moulding
Drying conditions	80 °C , 6 - 8 hours moisture content < 0,02%
Moulding temperature - Nozzle	235 - 255 °C
Moulding temperature - Barrel	230 - 250 °C
Mold Temperature	60 - 80 °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	240 mm/s
Cushion	4 - 6 mm
Back pressure	0 - 1,0 MPa

This information contained in this document is based on testing carried out by our laboratory. To the best of our knowledge and at the time of publication, this information is true and accurate. It shall however, in no event be held to constitute or imply warranty, undertaking express or implied commitment from the part of supplier. No liability whatsoever can be accepted by supplier with regard to the handling, processing or use of the product concerned which must in all cases be used in accordance with all applicable laws and regulations. Material is conform RoHS and Reach regulations and without heavy metals rev.date 28 03 2017.

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