



TECHNICAL DATASHEET

DIJBLEND D30 GF 10

PC/ABS Compound Glass Filled

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	260 °C/5 kg	g/10 min	30
Ash Content	Inhouse method	640 °C	%	10
Izod Impact Strength at 23 °C	ISO 180	notched	kJ/m ²	8
Izod Impact Strength at 23 °C	ISO 180	unnotched	kJ/m ²	38
Tensile Strength	ISO 527-1	1 mm/min	MPa	6500
Flexural Modulus	ISO 178	2 mm/min	GPa	3,6
Heat deflection temperature	ISO 75A	A	°C	122
Density	ISO 1183-1	method A	g/cm ³	1,23
Moldshrinkage	Inhouse method		%	0,45

Application data

Description	PC/ABS 10% Glassfilled Compound with good flow
Application	Injection Moulding
Drying conditions	100 °C , 6 - 8 hours moisture content < 0,01%
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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