

PC/ABS Compound | Colour: Black

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	260 °C/5 kg	g /10 min	25
Izod Impact Strength at 23°C	ISO 180	notched	kJ/m <sup>2</sup>	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 <sup>3</sup>	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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