

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

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