

General information

Description

PC/ABS with balanced flowability, impact properties and hydrolytic stability
 Non-brominated, non-chlorinated flame retardant
 High heat resistance

Applications

Wide variety of applications with OA and electronic housings

Typical properties¹

	Test method	Typical value	Unit
Physical			
Melt Flow Index, 260°C, 5 kg	ASTM D1238	-	g/10 min
Specific Gravity	ASTM D792	1.2	
Mold Shrinkage	ASTM D955	0.4~0.6	%
Mechanical			
Tensile Strength, yield, 50 mm/min	ASTM D638	630	kg _f /cm ²
Tensile Elongation, break, 50 mm/min	ASTM D638	> 60	%
Flexural Strength, yield, 10 mm/min	ASTM D790	880	kg _f /cm ²
Flexural Modulus, 10 mm/min	ASTM D790	23,000	kg _f /cm ²
IZOD Impact Strength, notched, 23°C, 1/8"	ASTM D256	60	kg _f -cm/cm
	ASTM D256	-	kg _f -cm/cm
	ASTM D256	-	kg _f -cm/cm
Thermal			
Heat Distortion Temp.	4.6 kg _f /cm ²	ASTM D648	- °C
	18.6 kg _f /cm ²	ASTM D648	120 °C
Vicat Softening Temp.	Rate B/50	ASTM D1525	- °C
Flammability			
UL94 V-0	UL94	1.5	mm
UL94 V-0	UL94	3.0	mm

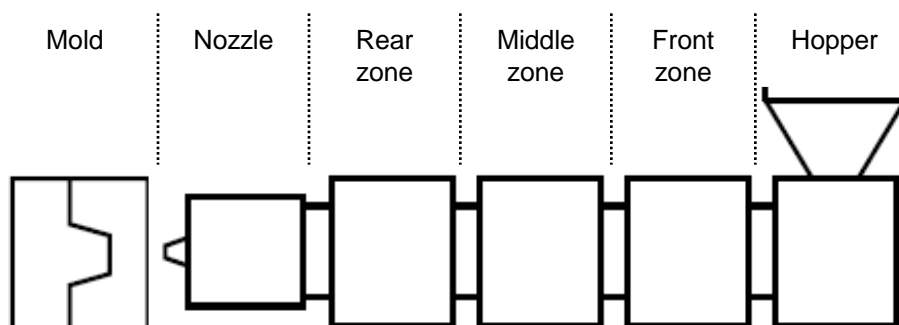
Notes

ISO 9001, 14001, TS 16949

¹ Typical properties : these are not to be construed as specifications.

Processing guides¹

	Typical value	Unit
Drying condition		
Drying temperature	80 ~ 90	°C
Drying time	4	hr
Maximum moisture content	0.02	%
Injection molding		
Melt temperature	240 ~ 260	°C
Nozzle temperature	240 ~ 260	°C
Barrel	Rear zone	240 ~ 260
	Middle zone	230 ~ 250
	Front zone	220 ~ 240
Hopper temperature	60 ~ 80	°C
Mold temperature	60 ~ 80	°C



Recycling

Sprues and runners can be reground with virgin resin within the ratio of 20%. Care must be taken to ensure that the regrind is free from impurities and regrind should not be used in applications where impact performance and/or agency compliance are required.

Notes

ISO 9001, 14001, TS 16949

¹ Processing guides : Typical processing parameters are noted. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.