

**Product Texts**

PC/ABS, low viscosity, high impact and ductile.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	9	g/10min	ASTM D 1238
Temperature	260	°C	-
Load	5	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	56	MPa	ASTM D 638
Elongation at Yield	5	%	ASTM D 638
Elongation at Break	150	%	ASTM D 638
Flexural Modulus	2340	MPa	ASTM D 790
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	534	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 66 psi	123	°C	ASTM D 648
DTUL @ 264 psi	107	°C	ASTM D 648
Thermal Conductivity, solid state	0.2	W/(m K)	ASTM C 177

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.1	%	ASTM D 570
Water Absorption, Equilibrium	0.4	%	ASTM D 570
Density	1140	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	105 - 110	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	275 - 300	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	250 - 290	°C	-
Zone 2	255 - 295	°C	-
Zone 3	260 - 300	°C	-
Nozzle temperature	275 - 300	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-