

Product Texts

- ABS PC-Blend
- Vicat/B 120 temperature = 112 °C
- for electroplating applications

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	12	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2100	MPa	ISO 527
^[C] Yield stress	49	MPa	ISO 527
^[C] Yield strain	3.7	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	95	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	112	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	110	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	85	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	90	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
^[C] Oxygen index	20	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	35	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	85	E-4	IEC 62631-2-1
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2
^[C] Electric strength	35	kV/mm	IEC 60243-1
^[C] Comparative tracking index	275	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.7	%	Sim. to ISO 62
^[C] Humidity absorption	0.2	%	Sim. to ISO 62
^[C] Density	1100	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	240	mm/s	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	70 - 100	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Platable

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Additives

Release agent

Other text information**Injection molding**

PREPROCESSING

Max. Water content: 0.02 %

Drying temperature: 100 - 110 °C

(depending on the grade 10°C below the Vicat VST/B120 temperature, but not higher as the recommended values).

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-4 h

PROCESSING

Melt temperature: 240-280 °C

Mold temperature: 70-100 °C

Use open nozzle.