

**Product Texts**

- (PC ABS)-Blend
- flame retardant
- Vicat/B 120 temperature = 108 °C
- increased heat resistance
- UL recognition 94 5VB (1,5 mm)
- glow wire temperature (GWFI): 960 °C at 2.0 mm

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	17	cm³/10min	ISO 1133
Temperature	240	°C	-
Load	5	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2700	MPa	ISO 527
<sup>[C]</sup> Yield stress	60	MPa	ISO 527
<sup>[C]</sup> Yield strain	4	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	88	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	98	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	106	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	76	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	80	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
<sup>[C]</sup> Burning Behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	1.5	mm	-
<sup>[C]</sup> Oxygen index	34	%	ISO 4589-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.5	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	0.2	%	Sim. to ISO 62
<sup>[C]</sup> Density	1180	kg/m³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	240	°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	75 - 100	°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

### Delivery form

Pellets

### Additives

Release agent

### Special Characteristics

Flame retardant

### Regional Availability

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

## Other text information

### Injection molding

#### PREPROCESSING

Max. Water content: 0.02 %

Drying temperature: 75 - 100 °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.