

Product Texts

- (PC ABS)-Blend
- flame retardant
- easy flowing
- for high gloss applications
- RHCM process etc.
- Vicat/B 120 temperature = 96 °C
- UL recognition 94 V-0 at 1.2 mm

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	31	cm ³ /10min	ISO 1133
Temperature	240	°C	-
Load	5	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2600	MPa	ISO 527
^[C] Yield stress	60	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	80	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	87	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	72	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	74	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	1.2	mm	-

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1200	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] 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

Special Characteristics

Flame retardant

Delivery form

Pellets

Regional AvailabilityNorth 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: 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.