

**Product Texts**

- (PC ABS)-Blend
- flame retardant
- easy flowing
- Vicat/B 120 temperature = 93 °C
- improved surface quality
- UL recognition 94 V-0 at 1.2 mm

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	<b>38</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>240</b>	°C	-
Load	<b>5</b>	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>2700</b>	MPa	ISO 527
<sup>[C]</sup> Yield stress	<b>60</b>	MPa	ISO 527
<sup>[C]</sup> Yield strain	<b>3.5</b>	%	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	<b>76</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	<b>85</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	<b>91</b>	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	<b>75</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	<b>75</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	<b>V-0</b>	class	IEC 60695-11-10
<sup>[C]</sup> Burning Behav. at thickness h	<b>V-0</b>	class	IEC 60695-11-10
Thickness tested	<b>1.2</b>	mm	-

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	<b>0.5</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>0.2</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1180</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

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

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>75 - 100</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>240 - 280</b>	°C	-
Mold temperature	<b>70 - 100</b>	°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.