

PC/ABS CB1230-GX

(PC+ABS)

Wellman Advanced Materials

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	18	g/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2150	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Strain at break	60	%	ISO 527
Flexural modulus, 23°C	2050	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	55	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	45	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	97	°C	ISO 75-1/-2
Vicat softening temperature, B	117	°C	ISO 306

Other properties	Value	Unit	Test Standard
Density	1120	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	95 - 105	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230 - 275	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	210 - 255	°C	-
Zone 2	215 - 260	°C	-
Zone 3	225 - 275	°C	-
Nozzle temperature	230 - 275	°C	-
Screw speed	40 - 70	rpm	-
Injection pressure	70 - 110	MPa	-
Back pressure	0.35 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Asia Pacific

Special Characteristics

High impact or impact modified