

**PC/ABS CB1230K**

(PC+ABS)

Wellman Advanced Materials

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	20	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
<b>ISO Data</b>			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	53	MPa	ISO 527
Yield strain	5	%	ISO 527
Stress at break	46	MPa	ISO 527
Strain at break	>50	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	82	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	55	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	32	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	101	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	122	°C	ISO 75-1/-2
Vicat softening temperature, B	122	°C	ISO 306

Other properties	Value	Unit	Test Standard
Density	1130	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°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