

PC/ABS CB3110

(PC+ABS)

Wellman Advanced Materials

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	23	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	2350	MPa	ISO 527
Yield stress	49	MPa	ISO 527
Yield strain	5	%	ISO 527
Stress at break	41	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus, 23°C	2350	MPa	ISO 178
Flexural strength	80	MPa	ISO 178

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	93	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	112	°C	ISO 75-1/-2
Vicat softening temperature, B	112	°C	ISO 306
Coeff. of linear therm. expansion, parallel	100	E-6/K	ISO 11359-1/-2
Other Standards^[5]			
Thermal Conductivity, solid state	0.24	W/(m K)	ISO 8302
Specific Heat	1240	J/(kg K)	ISO 11357-4

S: These properties are reported by the producer according standards that are different to our defaults.

Other properties	Value	Unit	Test Standard
Density	1110	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230 - 265	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	210 - 230	°C	-
Zone 2	215 - 240	°C	-
Zone 3	225 - 260	°C	-
Nozzle temperature	230 - 265	°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