PC/ABS CB3110-GX

(PC+ABS) Wellman Advanced Materials

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
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
ISO Data			
Tensile Modulus	**2050**	MPa	ISO 527
Yield stress	**44**	MPa	ISO 527
Strain at break	**>50**	%	ISO 527
Flexural modulus, 23°C	**2000**	MPa	ISO 178
Flexural strength	**68**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**50**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**40**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**91**	°C	ISO 75-1/-2
Vicat softening temperature, B	**110**	°C	ISO 306

Other properties	Value	Unit	Test Standard
Density	**1100**	kg/m³	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	-
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