

Product Texts

High ductility and impact at low temperature, for automotive interior applications, Vicat 123°C, High Flow

ISO 1043 (PC+ABS)

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Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	18	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
^[C] Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
^[C] Density of melt	1010	kg/m ³	-
^[C] Thermal conductivity of melt	0.23	W/(m K)	-
^[C] Spec. heat capacity of melt	2280	J/(kg K)	-
^[C] Eff. thermal diffusivity	1E-7	m ² /s	-
^[C] Ejection temperature	110	°C	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2200	MPa	ISO 527
^[C] Yield stress	50	MPa	ISO 527
^[C] Yield strain	4	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	50	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	45	kJ/m ²	ISO 179/1eA
^[C] Puncture energy, +23°C	65	J	ISO 6603-2
^[C] Puncture energy, -30°C	55	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	108	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	123	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	70	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	70	E-6/K	ISO 11359-1/-2
^[C] Oxygen index	22	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.6	%	Sim. to ISO 62
^[C] Humidity absorption	0.2	%	Sim. to ISO 62
^[C] Density	1120	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	280	°C	ISO 294

Injection Molding, mold temperature	80	°C	ISO 294
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[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.03	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	230 - 250	°C	-
Zone 2	235 - 255	°C	-
Zone 3	240 - 260	°C	-
Nozzle temperature	230 - 250	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Regional Availability

Europe

Other text information

Injection molding

[Injection Molding Recommendations](#)