

**Product Texts**

- PC ASA-Blend
- Vicat/B 120 temperature = 115°C
- UV-stabilized
- very good surface finish

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	<b>34</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>260</b>	°C	-
Load	<b>5</b>	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	<b>0.7</b>	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	<b>0.7</b>	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>2830</b>	MPa	ISO 527
<sup>[C]</sup> Yield stress	<b>65</b>	MPa	ISO 527
<sup>[C]</sup> Yield strain	<b>4</b>	%	ISO 527
Flexural modulus, 23°C	<b>2840</b>	MPa	ISO 178
Izod notched impact strength, +23°C	<b>14</b>	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	<b>7</b>	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	<b>-30</b>	°C	-
<sup>[C]</sup> Puncture - maximum force, +23°C	<b>4800</b>	N	ISO 6603-2
<sup>[C]</sup> Puncture - maximum force, -30°C	<b>4250</b>	N	ISO 6603-2
<sup>[C]</sup> Puncture energy, +23°C	<b>45</b>	J	ISO 6603-2
<sup>[C]</sup> Puncture energy, -30°C	<b>20</b>	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	<b>93</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	<b>112</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	<b>113</b>	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	<b>70</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	<b>70</b>	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Density	<b>1140</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	<b>260</b>	°C	ISO 294
Injection Molding, mold temperature	<b>75</b>	°C	ISO 294
Injection Molding, injection velocity	<b>240</b>	mm/s	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>95 - 110</b>	°C	-
Pre-drying - Time	<b>4</b>	h	-
Processing humidity	<b>≤0.01</b>	%	-
Melt temperature	<b>240 - 270</b>	°C	-
Mold temperature	<b>70 - 90</b>	°C	-
Zone 1	<b>220 - 230</b>	°C	-
Zone 2	<b>225 - 235</b>	°C	-

Zone 3	<b>230 - 240</b>	°C	-
Nozzle temperature	<b>255 - 265</b>	°C	-
Back pressure	<b>5 - 15</b>	MPa	-

### Characteristics

#### Processing

Injection Molding

#### Special Characteristics

U.V. stabilized or stable to weather

#### Regional Availability

North America, Europe, Asia Pacific, South and Central America,  
Near East/Africa