

**Product Texts**

- (PC ABS)-Blend
- Vicat/B 120 temperature = 112 °C
- excellent flow
- good low temperature impact strength

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	19	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2100	MPa	ISO 527
<sup>[C]</sup> Yield stress	50	MPa	ISO 527
<sup>[C]</sup> Yield strain	4.5	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	99	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	120	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	113	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	85	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	85	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	3	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	25	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	90	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<sup>[C]</sup> Electric strength	40	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	250	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.7	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	0.2	%	Sim. to ISO 62
<sup>[C]</sup> Density	1110	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	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	240	mm/s	ISO 294

[C]: CAMPUS

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>100 - 110</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>240 - 280</b>	°C	-
Mold temperature	<b>70 - 100</b>	°C	-

## Characteristics

### Processing

Injection Molding

### Additives

Release agent

### Delivery form

Pellets

### Regional Availability

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

## Other text information

### Injection molding

#### PREPROCESSING

Max. Water content: 0.02 %

Drying temperature: 100 - 110 °C

(depending on the grade 10°C below the Vicat VST/B120 temperature, but not higher as the recommended values).

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-4 h

#### PROCESSING

Melt temperature: 240-280 °C

Mold temperature: 70-100 °C

Use open nozzle.