

MABLEX® 273

(PC+ABS)

Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	14	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			
Yield stress	53	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	40	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Izod notched impact strength, +23°C	50	kJ/m ²	ISO 180/1A
Izod notched impact strength	35	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	105	°C	ISO 75-1/-2
Vicat softening temperature, A	125	°C	ISO 306
Vicat softening temperature, B	110	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.2	mm	-
Burning rate, FMVSS, Thickness 1 mm	53	mm/min	ISO 3795 (FMVSS 302)
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2
Electric strength	24	kV/mm	IEC 60243-1
Comparative tracking index	500	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	1100	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	225 - 240	°C	-
Zone 2	240 - 260	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	250 - 260	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 1.5	MPa	-
Holding pressure	3 - 7	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

Europe

Applications

General Purpose