

**MABLEX® 273F**

(PC+ABS)

Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	52	MPa	ISO 527
Stress at break	42	MPa	ISO 527
Strain at break	38	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Izod notched impact strength, +23°C	50	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	25	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
<b>Thermal properties</b>			
<b>ISO Data</b>			
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	-
<b>Electrical properties</b>			
<b>ISO Data</b>			
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
<b>Other properties</b>			
Density	1100	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
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