MABLEX® 280

(PC+ABS) Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**13**	g/10min	ISO 1133
Temperature	**260**	°C	-
Load	**5**	kg	-
Molding shrinkage, parallel	**0.5**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**62**	MPa	ISO 527
Stress at break	**54**	MPa	ISO 527
Strain at break	**45**	%	ISO 527
Flexural modulus, 23°C	**2400**	MPa	ISO 178
Izod notched impact strength, +23°C	**60**	kJ/m²	ISO 180/1A
Izod notched impact strength	**33**	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**110**	°C	ISO 75-1/-2
Vicat softening temperature, A	**138**	°C	ISO 306
Vicat softening temperature, B	**130**	°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	**35**	mm/min	ISO 3795 (FMVSS 302)
Glow Wire Flammability Index (GWFI)	**750**	°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	**250**	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	**1150**	kg/m³	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

Special Characteristics
Heat stabilized or stable to heat

Regional Availability
Europe