

MABLEX® 280F

(PC+ABS)

Ravago Group

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|-----------|-------------------|----------------------|
| ISO Data | | | |
| Melt flow index, MFI | 21 | g/10min | ISO 1133 |
| Temperature | 260 | °C | - |
| Load | 5 | kg | - |
| ASTM Data | | | |
| Mold Shrinkage, MD | 0.005 | mm/mm | ASTM D 955 |
| Mechanical properties | | | |
| 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 | 55 | kJ/m ² | ISO 180/1A |
| Izod notched impact strength | 28 | kJ/m ² | ISO 180/1A |
| Temperature | -30 | °C | - |
| Thermal properties | | | |
| 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 | | | |
| 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 | | | |
| Density | 1150 | kg/m ³ | ISO 1183 |
| Processing Recommendation Injection Molding | | | |
| 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

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Processing

Injection Molding

Regional Availability

Europe

Special Characteristics

Heat stabilized or stable to heat