

**MABLEX® 274SL05**

(PC+ABS+PTFE)

Ravago Group

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	18	g/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	45	MPa	ISO 527
Stress at break	35	MPa	ISO 527
Strain at break	60	%	ISO 527
Flexural modulus, 23°C	2450	MPa	ISO 178
Izod notched impact strength, +23°C	50	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	20	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Vicat softening temperature, B	121	°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	20	mm/min	ISO 3795 (FMVSS 302)

Other properties	Value	Unit	Test Standard
Density	1150	kg/m <sup>3</sup>	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

**Additives**

Lubricants