

CELEX™ 501.C

(PC+ABS)

Trinseo

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	8.3	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	3.8	kg	-
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Strength at Yield	50	MPa	ASTM D 638
Flexural Modulus	2261	MPa	ASTM D 790
Flexural Strength	84.1	MPa	ASTM D 790
Izod Impact notched, 1/8 in	534	J/m	ASTM D 256
Thermal properties			
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
DTUL @ 264 psi	100	°C	ASTM D 648
Other properties			
Density	1120	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	40 - 60	°C	-
Zone 1	215 - 230	°C	-
Zone 2	230 - 235	°C	-
Zone 3	235 - 240	°C	-
Nozzle temperature	240 - 250	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific

Special Characteristics

Heat stabilized or stable to heat