Prime ABS PC/ABS

Polycarbonate + ABS

Primex Plastics Corporation

Message:

This product is classified as an amorphous thermoplastic blend of ABS and Polycarbonate. This product is known for high impact and notched impact strength, stiffness, heat resistance, dimensional accuracy, low shrinkage, low warp, and light stability. This product is available in:
Non-reinforced general purpose
Non-reinforced flame retardant
Glass fiber reinforced
Acrylic co-extruded cap
Applications:
Some ideal application for Prime PC/ABS include the following:
Engine covers
Fan shrouds
Structural parts
Motorcycle fairings
Processing:
Forming temp. is 400°F, tool temperature is 150-200°F. The part can be de-molded at 200°F. Sheet should be dried before forming @ 180°F for 2-4 hrs.
Finishing:
Cutting or machining of this product may be done by sawing, drilling, grinding, sanding, punching and die cutting. High pressure and laser cutting will also work for this product. Prime PC/ABS may be bonded with chemical, mechanical screws and other type of fasteners as well as sonic welding.
Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.
Colors, Textures and Capabilities:
PC/ABS can be color matched to suit your needs. Several textures are available including, H/C, FL/HC, Calf Grain and more. Sheet thickness can range from .090-.400 and in widths of up to 120".

General Information			
Features	Amorphous		
	Bondability		
	Good Dimensional Stability		
	High Heat Resistance		
	High Impact Resistance		
	High Stiffness		
	Light Stabilized		
	Low Shrinkage		
	Low Warpage		
	Machinable		
	Ultrasonic Weldable		
Uses	Automotive Under the Hood		
	Electrical Housing		
	Structural Parts		
Appearance	Colors Available		
Forms	Sheet		
Processing Method	Thermoforming		
Physical	**Nominal Value**	**Unit**	**Test Method**

Specific Gravity	1.22	g/cm³	ASTM D792
Water Absorption (23°C, 24 hr)	0.10	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	3300	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	55.8	MPa	
Break	60.0	MPa	
Flexural Modulus	2990	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	430	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	138	°C	
1.8 MPa, Unannealed	126	°C	
Vicat Softening Temperature	118	°C	ASTM D1525
CLTE - Flow	6.6E-5	cm/cm/°C	ASTM E831
Additional Information	**Nominal Value**	**Unit**	
De-mold Temperature	93	°C	
Drying Temperature [1]	82	°C	
Forming Temperature	204	°C	
Tool Temperature	66 to 93	°C	
NOTE			
1.	2 to 4 hrs		

Recommended distributors for this material

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