

PRL PC/ABS-GP1

Polycarbonate + ABS
Polymer Resources Ltd.

Message:

PRL PC/ABS-GP1 is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in North America.

Characteristics include:

RoHS Compliant

Impact Resistant

General Information			
Features	General Purpose		
	Good Flow		
	High Impact Resistance		
	Medium Flow		
	Medium Impact Resistance		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	3.0 to 14	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	57.9	MPa	
Break, 3.18 mm	56.5	MPa	
Flexural Modulus (3.18 mm)	2280	MPa	ASTM D790
Flexural Strength (3.18 mm)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	530	J/m	
23°C, 3.18 mm	640	J/m	
Gardner Impact (3.18 mm)	36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	121	°C	
1.8 MPa, Unannealed, 3.18 mm	107	°C	
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 82.2	°C	
Drying Time	3.0 to 4.0	hr	

Drying Time, Maximum	8.0	hr
Rear Temperature	249 to 288	°C
Middle Temperature	254 to 293	°C
Front Temperature	260 to 302	°C
Processing (Melt) Temp	274 to 302	°C
Mold Temperature	71.1 to 93.3	°C

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