

AIE PC/ABS 12G6F

Polycarbonate + ABS

Asia International Enterprise (Hong Kong) Limited

Message:

AIE PC/ABS 12G6F is a polycarbonate + acrylonitrile butadiene styrene (PC + ABS) material, which contains a 30% glass fiber reinforced material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is injection molding. The main features of AIE PC/ABS 12G6F are:

- flame retardant/rated flame
- Flame Retardant
- Hard
- Good dimensional stability

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
	Flame retardancy		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage	0.10 - 0.30	%	Internal method
Water Absorption (23°C, 24 hr)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	108	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	6800	MPa	ISO 178
Flexural Stress	157	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	10	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	136	°C	ISO 75-2/B
1.8 MPa, not annealed	130	°C	ISO 75-2/A
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	210 - 280	°C	
Middle Temperature	220 - 290	°C	

Front Temperature	220 - 290	°C
Nozzle Temperature	200 - 270	°C
Mold Temperature	50.0 - 110	°C
Injection Pressure	30.0 - 80.0	MPa
Holding Pressure	40.0 - 50.0	MPa
Back Pressure	5.00 - 10.0	MPa
Screw Speed	40 - 70	rpm

Injection instructions

Cylinder Temperature 4: 190 to 240°C

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Recommended distributors for this material

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