

4LOY® 10E27200

Polycarbonate + ABS
4Plas

Message:

4LOY 10E27200 is a Standard Flow 65% PC / 35% ABS PC/ABS

General Information			
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Molding Shrinkage - Across Flow	0.40 - 0.60	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2250	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	45.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	50	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-30°C	20	kJ/m ²	ISO 180/1A
23°C	42	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	120	°C	ISO 75-2/B
1.8 MPa, not annealed	105	°C	ISO 75-2/A
Vicat Softening Temperature	115	°C	ISO 306/B
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		UL 94
3.20 mm	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Processing (Melt) Temp	230 - 260	°C	
Mold Temperature	60.0 - 90.0	°C	
Injection Rate	Moderate-Fast		

Holding Pressure	50.0 - 100	MPa
Screw Speed	200	rpm
Injection instructions		
Feed Throat Temperature: 60 - 80 °C Back Pressure: Low		
NOTE		
1.	24 Hrs	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

