

Gebablend 65 HI

Polycarbonate + ABS
geba Kunststoffcompounds GmbH

Message:

PC/ABS type with enhanced high impact unnotched and notched impact strength
Applications:
technical injection molded parts for various sectors (Automotive, Electrical, Electronic, Mechanical)

General Information			
Features	High Impact Resistance		
Uses	Automotive Applications		
	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	23.0	cm ³ /10min	ISO 1133
Molding Shrinkage	0.45 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1/1
Tensile Stress (Yield)	50.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	5.5	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	35	kJ/m ²	
23°C	45	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	122	°C	ISO 75-2/B
1.8 MPa, Unannealed	102	°C	ISO 75-2/A
Vicat Softening Temperature	120	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Drying Temperature - Dry Air Dryer	80.0 to 100	°C	
Drying Time - Dry Air Dryer	2.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	240 to 260	°C	
Middle Temperature	250 to 270	°C	

Front Temperature	250 to 280	°C
Nozzle Temperature	250 to 280	°C
Processing (Melt) Temp	250 to 280	°C
Mold Temperature	70.0 to 100	°C

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