

TAIRILOY AC3100

Polycarbonate + ABS
Formosa Plastics Corporation

Message:
FCFC PC/ABS resin AC3100 meets the requirements of UL, SGS and the certificates of environmental protection.

General Information			
UL YellowCard	E162823-318720		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
UL File Number	E162823		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.18	g/cm ³	ASTM D792
23°C	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/5.0 kg)	22	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class R, 23°C	118		ASTM D785
R scale, 23°C	118		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	62.0	MPa	ASTM D638, ISO 527-2
Flexural Modulus (23°C)	2750	MPa	ASTM D790, ISO 178
Flexural Strength (23°C)	94.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (23°C, 3.18 mm)	590	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	90.0	°C	ASTM D648, ISO 75-2/A
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm, All Colors	V-0		UL 94
	V-0		
2.30 to 2.53mm, All Colors	5VB		UL 94

V-0

3.00 mm, All Colors

5VA

UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 90.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	60.0 - 80.0	°C
Rear Temperature	200 - 230	°C
Middle Temperature	220 - 250	°C
Front Temperature	230 - 260	°C
Processing (Melt) Temp	230 - 260	°C
Mold Temperature	50.0 - 70.0	°C
Back Pressure	0.345 - 0.689	MPa

Injection instructions

Die Temperature: 220 to 250°C Injection Volume: 30 to 80% of injection machine's capacity

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