

Generic ABS+PC - Mineral

Polycarbonate + ABS

Generic

Message:

This data represents typical values that have been calculated from all products classified as: Generic ABS+PC - Mineral
This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement	Mineral filler		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25 - 1.30	g/cm ³	ASTM D792
Molding Shrinkage - Flow (23°C)	0.30 - 0.41	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 23°C	55.0 - 61.0	MPa	ASTM D638
Fracture, 23°C	35.0 - 51.2	MPa	ISO 527-2
Tensile Elongation			
Fracture, 23°C	4.0 - 90	%	ASTM D638
Fracture, 23°C	6.0 - 30	%	ISO 527-2
Flexural Modulus (23°C)	2450 - 5880	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	49 - 100	J/m	ASTM D256
23°C	5.0 - 9.3	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	87.3 - 105	°C	ASTM D648
Vicat Softening Temperature	92.0 - 142	°C	ISO 306
Injection	Nominal Value	Unit	Test Method
Drying Temperature	80.0 - 105	°C	
Drying Time	3.5	hr	
Suggested Max Moisture	0.020 - 0.040	%	
Rear Temperature	230 - 240	°C	
Middle Temperature	243 - 256	°C	
Front Temperature	260 - 268	°C	
Nozzle Temperature	259 - 269	°C	
Processing (Melt) Temp	259 - 260	°C	
Mold Temperature	70.0 - 71.3	°C	
Back Pressure	0.505 - 1.47	MPa	
Screw Speed	55	rpm	
Injection instructions			

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