

OP - PC/ABS 604-I-FR

Polycarbonate + ABS

Oxford Polymers

Message:

OP-PC/ABS 604-I-FR is a polycarbonate acrylonitrile butadiene styrene (PC ABS) material. This product is available in North America and is processed by injection molding.

The main features of OP-PC/ABS 604-I-FR are:

flame retardant/rated flame

Flame Retardant

General Information			
UL YellowCard	E186411-100971020		
Features	Good liquidity		
	Flame retardancy		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	35	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	53.8	MPa	ASTM D638
Fracture	55.2	MPa	ASTM D638
Flexural Modulus	2620	MPa	ASTM D790
Flexural Strength	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (4°C)	640	J/m	ASTM D256
Dart Drop Impact	36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	82.2	°C	ASTM D648
1.8 MPa, not annealed	73.9	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.59 mm	V-0		UL 94
3.18 mm	V-0		UL 94
Additional Information			
Melt Mass -Flow Rate (MFR), ASTM D1238, 285°C/ 2.16kg: 25 to 45 g/10 min			
Injection	Nominal Value	Unit	

Drying Temperature	76.7 - 82.2	°C
Drying Time	3.0 - 4.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	221 - 254	°C
Middle Temperature	232 - 266	°C
Front Temperature	243 - 277	°C
Processing (Melt) Temp	246 - 274	°C
Mold Temperature	48.9 - 82.2	°C

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