

KIMIALEX ABS/PC(48000N)

MATERIAL NAME: ABS/PC

COLOR: NATURAL

CODE: 48000N

MATERIAL DESCRIPTION: Kimialex[®] ABS/PC48000N is un- reinforced, lubricated, natural ABS/PC for injection molding.

No.	PROPERITES		METHOD	UNIT	VALUE
PHYSICAL PROPERTIES					
1	ASH CONTENT		ISO 3451	%	0.8
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.06
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.3
MECHANICAL PROPERTIES					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	46
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	100
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	2500
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	16.5
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	81.2
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	72
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	105
		50N			93
FLAMMABILITY					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	96
		66psi			103
14	Flammability	Class	UL94	-	-
INJECTION PROCESS PARAMETERS					
<i>Loading</i>		<i>Injection</i>		<i>Degassing</i>	
<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Temperature</i>	<i>Time</i>
60	80	60	80	80 °C	1h
<i>Mold Releasing</i>			<i>Zone</i>		
Good			5	4	3
			- °C	195 °C	200 °C
			2	1	
			205 °C	210 °C	