performanceplastics

PC/ABS 65S

PC/ABS 65 S alloy medium-high thermal resistance, good flow and mechanical properties, low moisture absorption and good dimensional stability.

Drying - Conditions	**Melt temperature:** 230 - 260°C
Pre-Heater: 80 - 100°C / 3 h	**Mould temperature:** 50 - 70°C
Dryer: 80°C / 1 h	**Rate of injection:** MEDIUM

PROPERTIES

Mechanical Properties

	Condition	Standard	Unit	Value
Izod notched impact	23°C	ASTM D256	J/m	550
Charpy notched impact	23°C	ISO 179/1eA	kJ/m²	35
Charpy unnotched Impact	23°C	ISO 179/1eU	kJ/m²	No Break
Tensile Modulus	Speed 1mm/min	ISO 527-1,2	MPa	2100
Flexural modulus	Speed 1mm/min	ISO 178	MPa	2150
Elongation at break	Speed 50mm/min	ISO 527-1,2	%	50
Tensile yield strength	Speed 50mm/min	ISO 527-1,2	MPa	50
Flexural max strength	Speed 1mm/min	ISO 178	MPa	80

Thermal Properties

Vicat temperature	1Kg 50°C/h	ISO 306	°C	130
Vicat temperature	5Kg 50°C/h	ISO 306	°C	125
Heat deflection temperature	1.82 Mpa 120°C/h	ISO 75A	°C	118
Ball Pressure Test		IEC 60695-10-2	°C	125
Continuous service temperature	20,000h	IEC 60216	°C	90
Coefficient of linear thermal exp.	-30°C/+30°C	ISO 11359-1,-2	K^-1	6.5x10exp(-5)

Electrical Properties

Dielectric strength	2mm	IEC 60243-1	kV/mm	24
Comparative tracking index	CTI -Method A	IEC 60112	Volt	250
Volume resistivity		IEC 60093	Ohm cm	>10exp(15)

Flammability

Oxygen index		ASTM D2863	%	23
Flame behaviour (yellow card)	1.6mm	UL94	Class	HB
Burning Rate	(US-FMVSS 302)	ISO 3795	mm/min	<101.6

General Properties

Density		ISO 1183	g/cm³	1.13-1.15
Melt flow rate	260°C-5Kg	ISO 1133	g/10 min	12
Water absorption	24h/23°C	ISO 62	%	0.20
Water absorption at saturation		ISO 62	%	0.60
Mould Shrinkage	Parallel		%	0.4-0.7
Mould Shrinkage	Normal		%	0.4-0.7

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