# Datasheet

## PC / ABS Gebablend 85

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Description according to ISO 1043 >PC/ABS (REC100) <

**Properties:**

PC/ABS injection moulding type, based on recyclate

**Applications:**

Technical injection moulded parts, e.g in the automotive sector, electrical sector, household sector

| Properties[1)2)] | Test condition | Unit | Standard | Value |
|---|---|---|---|---|
| **Rheolocical Properties** | | | | |
| MVR | 260 °C / 5 kg | cm³/10 min | ISO 1133-2 | 23 |
| **Machanical Properties** | | | | |
| Charpy unnotched impact strength | 23 °C | kJ/m² | ISO 179/1eU | No Break |
| Charpy notched impact strength | 23 °C | kJ/m² | ISO 179/1eA | 38 |
| Tensile modulus | 1 mm/min | MPa | ISO 527 od. ISO 53504 | 2.300 |
| Yield Stress | 50 mm/min | MPa | ISO 527 | 50 |
| Yield Strain | 50 mm/min | % | ISO 527 | 5,5 |
| **Thermical properties** | | | | |
| Vicat softening temperature | VCT B50 | °C | ISO 306 | 128 |
| Heat deflection temperature | 1,8 MPa | °C | ISO 75 | 109 |
| Heat deflection temperature | 0,45 MPa | °C | ISO 75 | 128 |
| **Processing conditions for test specimens** | | | | |
| Injection molding – Meld temperature | | | ISO 294 | 260 |
| Injection molding – Mold temperature | | | ISO 294 | 80 |
| **Other properties** | | | | |
| Density | 23°C | g/cm³ | ISO 1183-1-A | 1,16 |
| Burning behaviour | 2 mm | mm/min | FMVSS 302 | < 100 |
| Shrinkage [3)] | | % | ISO 294-4 | 0,45 – 0,8 |

1) Typical data. Deviations within normal tolerances are possible.

2) Standard values for material comparison - not basis for component and tool design

3) The shrinkage can vary due to the process conditions

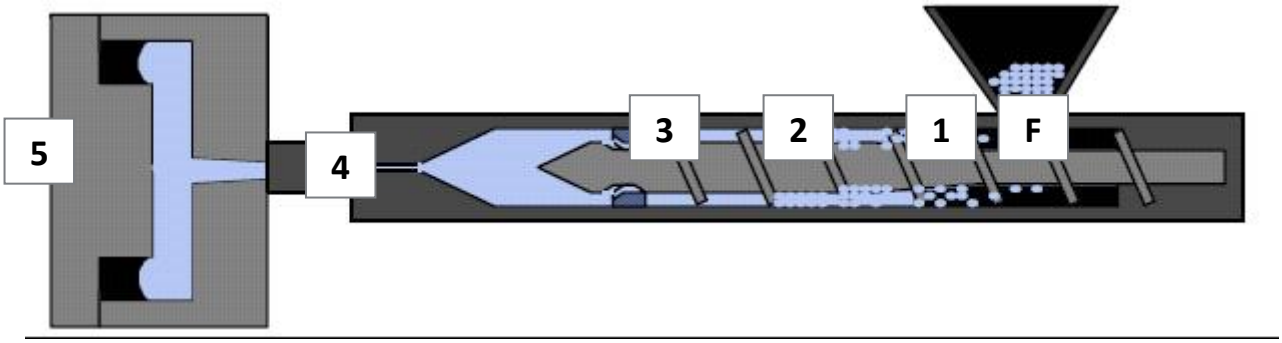
# Processing Recommendations

## Drying recommendations

| Recommended drying temperatures and times | |
|---|---|
| Drying temperature (dry air dryer) | 80 - 100 °C |
| Drying time | 2 - 4 h |
| Max. residual moisture | 0,02 % |

For downtimes of more than 4 hours we recommend a temperature reduction of the dryer by 40°C

## Processing temperatures




| Mass temperature: 240 - 270 °C | | | | | |
|---|---|---|---|---|---|
| 5. Mold | 4. Nozzle | 3. Zone | 2. Zone | 1. Zone | Feeding zone |
| 60 - 90 °C | 240 - 270 °C | 240 - 260 °C | 240 - 260 °C | 240 °C | 60 - 80°C |

**The values given are based on experience and should be regarded as guidelines.**

**Test values**

The stated values were – if not otherwise stated – taken on standardized test specimen at room ambient temperature. The specifications have to be regarded as guidance values, but not as binding minimum values. Please note that the properties can be considerably influenced by mould design, processing parameters and coloring.

**Processing information**

When processing on the basis of the recommended processing parameters, small quantities of dissociation products can emit. According to the safety data sheet, the workplace exposure limit has to be kept by means of adequate exhaustion and ventilation, in order not to affect the machine operators' health and well-being. The compulsory processing temperatures must not be considerably exceeded, in order to avoid a stronger partial decomposition of the polymers and dissociation of volatile decomposition products.