

### PC / ABS Gebablend 85

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

#### Properties:

PC/ABS injection moulding type, based on recycle

#### Applications:

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

Properties <sup>1)2)</sup>	Test condition	Unit	Standard	Value
<b>Rheological Properties</b>				
MVR	260 °C / 5 kg	cm <sup>3</sup> /10 min	ISO 1133-2	23
<b>Machanical Properties</b>				
Charpy unnotched impact strength	23 °C	kJ/m <sup>2</sup>	ISO 179/1eU	No Break
Charpy notched impact strength	23 °C	kJ/m <sup>2</sup>	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
<b>Thermal properties</b>				
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
<b>Processing conditions for test specimens</b>				
Injection molding – Meld temperature			ISO 294	260
Injection molding – Mold temperature			ISO 294	80
<b>Other properties</b>				
Density	23°C	g/cm <sup>3</sup>	ISO 1183-1-A	1,16
Burning behaviour	2 mm	mm/min	FMVSS 302	< 100
Shrinkage <sup>3)</sup>		%	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

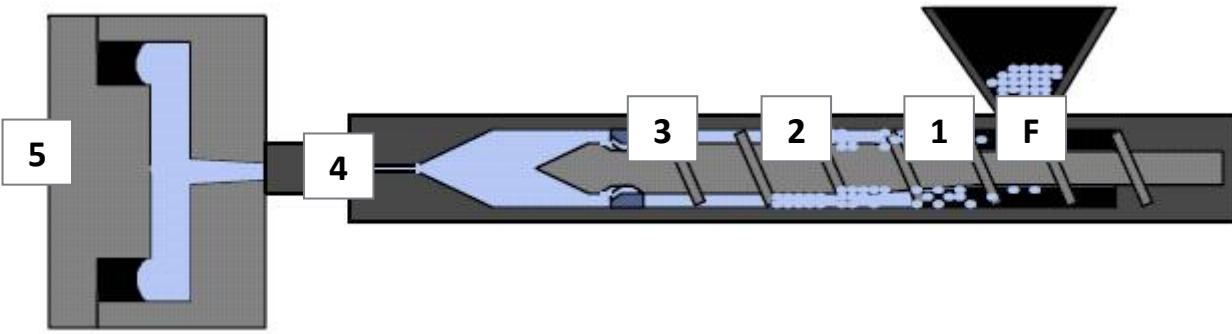
# Processing Recommendations

## 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.

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