

Material Type	PC/ABS	Trademark	Grade Name
Feature		•	PC/ABS CB1230HF
Material Standard		• XXXXXX	
Availability		• Asian-Pacific, America	
Processing method		• Injection Molding	
Appearance		• Color is Optional	
Applications		• Automotive and Engineering parts	

General Properties

No.	Properties	Unit	Typical Value	Method	Test condition
1	Density	g/mL	1.13	ISO 1183	23 °C
2	Tensile Strength, Yield	MPa	52	ISO 527	50 mm/mm
3	Elongation at Yield	%	5	ISO 527	50 mm/mm
4	Tensile Strength, Break	MPa	45	ISO 527	50 mm/mm
5	Elongation at Break	%	≥40	ISO 527	50 mm/mm
6	Poisson's Ratio		0.38	ISO 527	1 mm/min
7	Tensile Modulus	MPa	2,350	ISO 527	1 mm/min
8	Flexural Strength	MPa	81	ISO 178	2 mm/mm
9	Flexural Modulus	MPa	2,300	ISO 178	2 mm/mm
10	Notched Charpy Impact	kJ/m ²	52	ISO 179/1eA	23 °C
11	Charpy Impact	kJ/m ²	NB	ISO 179/1eU	23 °C
12	Notched Charpy Impact	kJ/m ²	27	ISO 179/1eA	-30°C
13	Vicat Softening Temperature	°C	121	ISO 306	5kg, 50°C/h
14	Heat Deflection Temperature	°C	101	ISO 75	1.8 MPa
15	Heat Deflection Temperature	°C	121	ISO 75	0.45MPa
16	Melt Flow Index	g/10min	24	ISO 1133	260°C, 5kg

Processing Conditions

Drying condition	90-100 °C, 2-4 h
Molding Temp.	230 - 280 °C (F), 220 - 260 °C (M), 210 - 230 °C (B)
Nozzle Temp.	230 - 280 °C
Mold Temp.	50 - 80 °C
Screw Speed	40 - 70 rpm
Injection Pressure	70 - 120 MPa
Back Pressure	0.40 – 0.70 MPa

Notes: This technical data in the product brochures are typical test results for reference, and should not be defined as minimum value.