Technical Datasheet

Material Type PC ABS	**Trademark**	**Grade Name PC/ABS CB1230**
Feature	•	
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 ℃
2	Tensile Strength, Yield	MPa	53	ISO 527	50 mm/mm
3	Elongation at Yield	%	5	ISO 527	50 mm/mm
4	Elongation at Break	%	≥50	ISO 527	50 mm/mm
5	Poisson's Ratio		0.34	ISO 527	1 mm/min
6	Tensile Modulus	MPa	2,350	ISO 527	1 mm/min
7	Flexural Strength	MPa	82	ISO 178	2 mm/mm
8	Flexural Modulus	MPa	2,300	ISO 178	2 mm/mm
9	Notch Charpy Impact Strength	kJ/m^2	55	ISO 179/1eA	23 ℃
10	Charpy Impact Strength	kJ/m2	NB	ISO 179/1eU	23 ℃
11	Notched Charpy Impact	kJ/m2	32	ISO 179/1eA	-30℃
12	Heat Deflection Temperature	℃	101	ISO 75	1.8 MPa
13	Heat Deflection Temperature	℃	122	ISO 75	0.45MPa
14	Vicat Softening Temperature	℃	122	ISO 306	5kg, 50℃/h
15	Flammability	mm/min	29	ISO 3795	3mm
16	Melt Flow Index	g/10min	20	ISO 1133	260℃, 5kg
17	Shrinkage	%	0.5-0.7	ISO 294	23 ℃, 48h

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Processing Conditions

Drying Temperature	100-110℃ 2-4hrs
Molding Temp.	220 - 275 ℃ (F)， 220 - 260 ℃ (M)，210 - 260 ℃ (B)
Melt Temp.	230 - 280 ℃
Mold Temp.	50 - 70 ℃
Screw Speed	40 - 70 rpm
Injection Pressure	70 - 110 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.