



Document	ISO Datasheet
Description	PC/ABS
Grade	A 85
Code	
Application	Injection moulding

Unfilled PC/ABS alloy.

Properties	Method	Unit	Value
<b>Physical</b>			
Melt Flow Rate (260°C - 5,00 Kg)	ISO 1133	g/10'	15
Density at 23°C	ISO 1183	g/cm3	1,15-1,16
<b>Thermal</b>			
Vicat B50	ISO 306	°C	129
HDT, A (1.80 MPa)	ISO 75/Af	°C	105
<b>Mechanical at 23 °C</b>			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	2500
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	55
Tensile elong. at break (23°C-50 mm/min)	ISO 527-2	%	>50
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m <sup>2</sup>	55
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m <sup>2</sup>	55
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m <sup>2</sup>	NB
<b>Flammability Class</b>			
Flammability class (1,6 mm)	UL94		HB
Flammability class (3,2 mm)	UL94		HB
<b>Processing Conditions</b>			
Melt Temperature Range	ISO 294	°C	270
Mold Temperature Range	ISO 294	°C	90
Injection Velocity	ISO 294		HIGH
Drying Temperature		°C	90-100
Drying Time		Hour	3
<b>Regulations compliance</b>			
RoHS compliance status	COMPLIANT		
EN71			

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UL listed file n°

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Water contact approvals

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Food contact status

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<sup>§</sup> Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 3.0 x 12.7 x 127 mm sample.

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