



Document	ISO Datasheet
Description	PC/ABS
Grade	DAFNEBLEND PM 500
Code	
Application	Injection moulding

Unfilled PC/ABS alloy. Good mechanical characteristics.

Properties	Method	Unit	Value
Physical			
Melt Flow Rate (260°C - 5,00 Kg)	ISO 1133	g/10'	15
Density at 23°C	ISO 1183	g/cm ³	1,13-1,15
Mould Shrinkage (%)	INTERNAL	%	0,4-0,7
Thermal			
Vicat A50	ISO 306	°C	125
Vicat B50	ISO 306	°C	118
HDT, A (1.80 MPa)	ISO 75/Af	°C	100
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	2500
Flexural strenght (23°C - 2 mm/min)	ISO 178	MPa	85
Tensile Modulus (23°C - 1 mm/min)	ISO 527-2	MPa	2500
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	50
Tensile elong. at break (23°C-50 mm/min)	ISO 527-2	%	>50
Rockwell hardness (M scale)	ISO 2039-2		30
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m ²	45
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m ²	45
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m ²	NB
Flammability			
Glow Wire Flammability Index GWFI (1,0 mm)	IEC 60695-2-12	°C	650
Glow Wire Flammability Index GWFI (2,0 mm)	IEC 60695-2-12	°C	650
Flammability class (1,6 mm)	UL94		HB
Flammability class (3,2 mm)	UL94		HB
Processing Conditions			

Melt Temperature Range	ISO 294	°C	260
Mold Temperature Range	ISO 294	°C	60-80
Injection Velocity	ISO 294		HIGH
Drying Temperature		°C	90-100
Drying Time		Hour	3
Regulations compliance			
RoHS compliance status:	COMPLIANT		
EN71:			
UL listed file n°:	QMFZ2.E220931		
Water contact approvals.			
Food contact status:			

§ 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 4.0 x 10.0 x 170 mm sample.

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