

Document	ISO Datasheet
Description	PC/ABS
Grade	A 65 GF20
Code	
Application	Electric covers and boxes, seats, dashboard, door and trunk components.

Blend PC/ABS 20% glass fiber reinforced.

Properties	Method	Unit	Value
<b>Physical</b>			
Density at 23°C	ISO 1183	g/cm <sup>3</sup>	1,29
Mould Shrinkage (%)	INTERNAL	%	0,2-0,4
Filler Content (1h/600°C)	ISO 3451-1	%	20
<b>Thermal</b>			
Vicat B50	ISO 306	°C	130
HDT, A (1.80 MPa)	ISO 75/Af	°C	125
<b>Mechanical at 23 °C</b>			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	4500
Tensile stress at yield (23°C-5 mm/min)	ISO 527-2	MPa	100
Tensile elong. at break (23°C-5 mm/min)	ISO 527-2	%	5,0
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m <sup>2</sup>	9
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m <sup>2</sup>	9
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m <sup>2</sup>	90
<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	250-270
Mold Temperature Range	ISO 294	°C	60-80
Injection Velocity	ISO 294		HIGH
Drying Temperature		°C	90-100
Drying Time		Hour	3
<b>Regulations compliance</b>			

RoHS compliance status	COMPLIANT
EN71	
UL listed file n°	
Water contact approvals	
Food contact status	

<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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