



Document	ISO Datasheet
Description	PC/ABS FR
Grade	DAFNEBLEND PM700/XF
Code	
Application	COFFE MACHINE

Unfilled PC/ABS. Flame retardant grade without halogens.

Properties	Method	Unit	Value
Physical			
Melt flow rate (260°C – 5,00 Kg)	ISO 1133	g/10'	29
Density at 23°C	ISO 1183	g/cm ³	1,18
Mould Shrinkage (%)	INTERNAL	%	0,4 – 0,7
Thermal			
Vicat B50	ISO 306	°C	108
HDT, A (1.80 MPa)	ISO 75/Ae	°C	90
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	2300
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	65
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m ²	40
Flammability			
Flammability class (1,5 mm)	UL94		V0
Processing Conditions			
Melt Temperature Range	ISO 294	°C	250 - 270
Mold Temperature Range	ISO 294	°C	70 - 90
Injection Velocity	ISO 294		High
Drying Temperature		°C	80
Drying Time		h	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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