

### ISOBLEND® - PC/ABS alloy

Structure	Amorphous
Density	1.12 g/cm <sup>3</sup> (unfilled)
General properties	High flow, good dimensional and thermal stability.
Barrel temperature	(decrease 15°C for flame retardant grades)
Feed zone:	50 – 70 °C
Zone 1:	230 – 250 °C
Zone 2:	240 – 260 °C
Zone 3:	250 – 270 °C
Zone 4:	250 – 270 °C
Zone 5:	250 – 270 °C
Nozzle:	250 – 270 °C
Melt temperature	250 – 270 °C
Mould temperature	70 – 90 °C
Injection pressure	90 – 150 bar
Post-pressure	Between 40 and 60% of injection pressure, low post-pressure time
Counterpressure	50 – 150 bar
Injection speed	Medium
Screw speed	Equal to peripheric speed of 0.4 m/s
Metering	1 – 3 diameters
Cushion	2 – 5 mm, depends on metering and screw diameter
Drying	4 hours at 80°C
Recycle	Maximum 20% of regrinded material. This percentage decreases for technical and aesthetic parts.
Shrinkage	0.4 – 0.7% (for unfilled product)
Barrel equipment	Standard screw, non-return valve, free-flow nozzle
Quenching	Not necessary to purge with other materials, however always empty the barrel. Purge with natural product suggested after flame retardant processing.