



Kimia Baspar Golpa

FRPC/ABS140

Flame Retardant PC/ABS Grade

General Information

● **Characteristic:** General purpose > Flame Retardant ABS/PC

● **Application:** ABS/PC140 is an unreinforced PC/ABS alloy which offers good impact strength and heat resistance. Typical applications include automotive instrument panel, automotive interior and exterior trim. Electrical and Electronic component and etc.

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	20
Rock well hardness	ASTM D-785	R-Scal	Shore D	117
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	45
Tensile modulus			Mpa	2250
Elongation at Yield			%	4
Elongation at break			%	20
Flexural modulus	ASTM D790	23°C	Mpa	2300
Flexural strength			Mpa	65
Flammability				
Flammability	UL94	⅜ inch (3.2 mm)	V-0(1.6MM)	V-0(1.6MM)
Thermal Property				
HDT(Heat Deflection	ASTM D648	unannealed1.82MPa	°C	85
Polymer property				
Melt flow index	ASTM D1238	260°C , 5kg	g/10min	50
Density	ASTMD792	23°C	g/cm3	1/13
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.5~0.7

1-The above data are typical values, they are only for material selection purpose, and variation within normal tolerances are for various color typical values are not our specification and not be used for part or tool design.

2-all properties, except Melt Flow Index are measured on injection molded specimens and after 48 hour storage at 23°C and in RH of 50%.

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Processing guid (Injection molding condition)

Processing parameters	unit	value
Drying Temperature	°C	60~80
Drying Time	hrs	2~3
Moisture content	%	<0.1
Melt Temperature	°C	220~230
Cylinder Temperature	Reare	°C 220~230
	Middle	°C 220~230
	Front	°C 220~230
Nozzel Temperature	°C	230~240
Mold Temperature	°C	60~80
Back Pressure	kg/cm2	150~500
Screw Speed	rpm	30~60

Note): Some modifications may be required depending on the specific molding equipment and part configuration.

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