



# Kimia Baspar Golpa

## FRPC/ABS 160 Flame Retardant PC/ABS Alloy

### General Information

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

● **Application:** ABS/PCFR150 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      | 30             |
| Rock well hardness      | ASTM D-785  | R-Scal            | Shore D    | 120            |
| Tensile stress at yield | ASTM D638   | 23°C , 50 mm/min  | Mpa        | 50             |
| Tensile modulus         |             |                   | Mpa        | 2300           |
| Elongation at Yield     |             |                   | %          | 4              |
| Elongation at break     |             |                   | %          | 25             |
| Flexural modulus        | ASTM D790   | 23°C              | Mpa        | 2400           |
| Flexural strength       |             |                   | Mpa        | 70             |
| 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         | 90             |
| Polymer property        |             |                   |            |                |
| Melt flow index         | ASTM D1238  | 2600°C , 5kg      | g/10min    | 45             |
| 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     | 70~90      |
| 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     | 220~230    |
| 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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