



Kimia Baspar Golpa

PC/ABS 140

General Grade

General Information

● **Characteristic:** General purpose > Injection grade > Medium Impact

● **Application:** ABS/PC140 is an unreinforced PC/ABS alloy which offers good impact strength and heat resistance. Especially, metal plating is very good. So it could be used outdoor housing which need metal plating such as, automotive door handle, lamp housing, etc

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	35
Rock well hardness	ASTM D-785	R-Scal	Shore D	117
Tensile stress at yield	ASTM D638	23°c , 50 mm/min	Mpa	50
Tensile modulus			Mpa	2400
Elongation at Yield			%	4
Elongation at break			%	20
Flexural modulus	ASTM D790	23°c	Mpa	2550
Flexural strength			Mpa	70
Flammability				
Flammability	UL94	⅜ inch (3.2 mm)	HB	HB
Thermal Property				
HDT(Heat Deflection	ASTM D648	unannealed1.82MPa	°C	100
Polymer property				
Melt flow index	ASTM D1238	260°c , 5kg	g/10min	42
Density	ASTMD792	23°c	g/cm3	1/1
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 colors.

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	70~100
Drying Time	hrs	2~3
Moisture content	%	<0.1
Melt Temperature	°C	220~240
Cylinder Temperature	Reare	°C 220~240
	Middle	°C 220~240
	Front	°C 220~240
Nozzel Temperature	°C	220~250
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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