

UMG ALLOY® TC-6F

Polycarbonate + ABS

UMG ABS, Ltd.

Message:

UMG ALLOY® TC-6F is a Polycarbonate + ABS (PC+ABS) material. It is available in Asia Pacific or North America for injection molding.

Important attributes of UMG ALLOY® TC-6F are:

Flame Rated

RoHS Compliant

General Information			
UL YellowCard	E47016-101255614		
RoHS Compliance	RoHS Compliant		
UL File Number	E47016		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.11	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	8.50	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.50 to 0.70	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2000	MPa	ISO 527-2
Tensile Stress (23°C)	48.0	MPa	ISO 527-2
Flexural Modulus ¹ (23°C)	2200	MPa	ISO 178
Flexural Stress ² (23°C)	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	30	kJ/m ²	
23°C	50	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	99.0	°C	ISO 75-2/Af
CLTE - Flow	8.5E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	210 to 230	°C	
Middle Temperature	230 to 250	°C	

Front Temperature	230 to 270	°C
Nozzle Temperature	220 to 250	°C
Processing (Melt) Temp	230 to 280	°C
Mold Temperature	60.0 to 80.0	°C
Injection Pressure	70.0 to 140	MPa
Injection Rate	Moderate	
Back Pressure	5.00 to 15.0	MPa
Screw Speed	50 to 100	rpm

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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