

# 4LOY® 10E17300

Polycarbonate + ABS

4Plas

Message:

4LOY 10E17300 is a MFI 14 to 16 85% PC / 15% ABS PC/ABS

| General Information                                       |                   |                   |                |
|-----------------------------------------------------------|-------------------|-------------------|----------------|
| Processing Method                                         | Injection molding |                   |                |
| Physical                                                  | Nominal Value     | Unit              | Test Method    |
| Density                                                   | 1.15              | g/cm <sup>3</sup> | ISO 1183       |
| Molding Shrinkage - Flow                                  | 0.40 - 0.60       | %                 |                |
| Water Absorption <sup>1</sup> (Equilibrium, 23°C, 50% RH) | 0.20              | %                 | ISO 62         |
| Mechanical                                                | Nominal Value     | Unit              | Test Method    |
| Tensile Modulus (23°C)                                    | 2300              | MPa               | ISO 527-2/5    |
| Tensile Stress                                            |                   |                   | ISO 527-2/5    |
| Yield, 23°C                                               | 55.0              | MPa               | ISO 527-2/5    |
| Fracture, 23°C                                            | 45.0              | MPa               | ISO 527-2/5    |
| Tensile Strain                                            |                   |                   | ISO 527-2/5    |
| Yield, 23°C                                               | 4.7               | %                 | ISO 527-2/5    |
| Fracture, 23°C                                            | 50                | %                 | ISO 527-2/5    |
| Impact                                                    | Nominal Value     | Unit              | Test Method    |
| Notched Izod Impact                                       |                   |                   | ISO 180/1A     |
| -30°C                                                     | 42                | kJ/m <sup>2</sup> | ISO 180/1A     |
| 23°C                                                      | 46                | kJ/m <sup>2</sup> | ISO 180/1A     |
| Thermal                                                   | Nominal Value     | Unit              | Test Method    |
| Heat Deflection Temperature                               |                   |                   |                |
| 0.45 MPa, not annealed                                    | 125               | °C                | ISO 75-2/B     |
| 1.8 MPa, not annealed                                     | 109               | °C                | ISO 75-2/A     |
| Vicat Softening Temperature                               | 128               | °C                | ISO 306/B      |
| Flammability                                              | Nominal Value     | Unit              | Test Method    |
| Flame Rating (1.60 mm)                                    | HB                |                   | UL 94          |
| Glow Wire Ignition Temperature (2.00 mm)                  | 650               | °C                | IEC 60695-2-13 |
| Injection                                                 | Nominal Value     | Unit              |                |
| Drying Temperature                                        | 110               | °C                |                |
| Drying Time                                               | 2.0 - 4.0         | hr                |                |
| Suggested Max Moisture                                    | 0.020             | %                 |                |
| Processing (Melt) Temp                                    | 230 - 260         | °C                |                |
| Mold Temperature                                          | 60.0 - 90.0       | °C                |                |
| Injection Rate                                            | Moderate-Fast     |                   |                |

|                                                        |            |     |
|--------------------------------------------------------|------------|-----|
| Holding Pressure                                       | 50.0 - 100 | MPa |
| Screw Speed                                            | < 200      | rpm |
| Injection instructions                                 |            |     |
| Feed Throat Temperature: 60 - 80 °C Back Pressure: Low |            |     |
| NOTE                                                   |            |     |
| 1.                                                     | 24 Hrs     |     |

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