

# ESTABLEND 6500 GF

Polycarbonate + ABS

Cossa Polimeri S.r.l.

Message:

ESTABLEND 6500 GF is a polycarbonate acrylonitrile butadiene styrene (PC ABS) product. It is available in Europe. ESTABLEND 6500 GF applications include electrical appliances and engineering/industrial accessories.

- Features include:
- flame retardant/rated flame
  - Impact resistance
  - Heat resistance

| General Information                      |                         |                   |                         |
|------------------------------------------|-------------------------|-------------------|-------------------------|
| Features                                 | Impact resistance, high |                   |                         |
|                                          | Heat resistance, high   |                   |                         |
| Uses                                     | Electrical appliances   |                   |                         |
|                                          | Engineering accessories |                   |                         |
| Forms                                    | Particle                |                   |                         |
| Physical                                 | Nominal Value           | Unit              | Test Method             |
| Specific Gravity                         | 1.14                    | g/cm <sup>3</sup> | ASTM D792               |
| Melt Mass-Flow Rate (MFR) (260°C/5.0 kg) | 32                      | g/10 min          | ASTM D1238              |
| Molding Shrinkage - Flow                 | 0.50 - 0.70             | %                 | ASTM D955               |
| Mechanical                               | Nominal Value           | Unit              | Test Method             |
| Tensile Strength                         |                         |                   | ASTM D638               |
| Yield                                    | 59.0                    | MPa               | ASTM D638               |
| Fracture                                 | 47.0                    | MPa               | ASTM D638               |
| Tensile Elongation (Yield)               | 45                      | %                 | ASTM D638               |
| Flexural Modulus                         | 2300                    | MPa               | ASTM D790               |
| Impact                                   | Nominal Value           | Unit              | Test Method             |
| Notched Izod Impact                      |                         |                   | ASTM D256               |
| 0°C                                      | 450                     | J/m               | ASTM D256               |
| 23°C                                     | 500                     | J/m               | ASTM D256               |
| Thermal                                  | Nominal Value           | Unit              | Test Method             |
| Vicat Softening Temperature              |                         |                   |                         |
| --                                       | 136                     | °C                | ASTM D1525 <sup>1</sup> |
| --                                       | 124                     | °C                | ASTM D1525 <sup>2</sup> |
| Flammability                             | Nominal Value           | Unit              | Test Method             |
| Flame Rating                             |                         |                   | UL 94                   |
| 1.60 mm                                  | HB                      |                   | UL 94                   |
| 3.20 mm                                  | HB                      |                   | UL 94                   |
| Glow Wire Ignition Temperature           | 750                     | °C                | IEC 60695-2-13          |

| Injection                  | Nominal Value | Unit |
|----------------------------|---------------|------|
| Drying Temperature         | 90.0          | °C   |
| Drying Time                | 2.0           | hr   |
| Processing (Melt) Temp     | 220 - 250     | °C   |
| Mold Temperature           | 50.0 - 80.0   | °C   |
| Injection Rate             | Moderate      |      |
| Injection instructions     |               |      |
| Injection Pressure: Medium |               |      |
| NOTE                       |               |      |
| 1.                         | 压 力1 (10N)    |      |
| 2.                         | 载 荷2 (50N)    |      |

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### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

