

4LOY® 10E07200

Polycarbonate + ABS
4Plas

Message:

4LOY 10E07200 is a Extrusion 65% PC / 35% ABS PC/ABS

General Information			
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2200	MPa	ISO 527-2/5
Tensile Stress			ISO 527-2/5
Yield, 23°C	52.0	MPa	ISO 527-2/5
Fracture, 23°C	45.0	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield, 23°C	4.2	%	ISO 527-2/5
Fracture, 23°C	50	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	60	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	122	°C	ISO 75-2/B
1.8 MPa, not annealed	100	°C	ISO 75-2/A
Vicat Softening Temperature	118	°C	ISO 306/B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+13	ohms · cm	IEC 60093
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
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

Extrusion	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Melt Temperature	230 - 260	°C
Die Temperature	60.0 - 90.0	°C

NOTE

1. 24 Hrs

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