

TAIRILOY AC2500

Polycarbonate + ABS
Formosa Plastics Corporation

Message:
FCFC PC/ABS resin AC2500 meets the requirements of SGS and the certificates of environmental protection.

General Information			
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.14	g/cm ³	ASTM D792
23°C	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/5.0 kg)	7.5	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class R, 23°C	110		ASTM D785
R scale, 23°C	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	52.0	MPa	ASTM D638, ISO 527-2
Flexural Modulus (23°C)	2450	MPa	ASTM D790, ISO 178
Flexural Strength (23°C)	89.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (23°C, 3.18 mm)	570	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.35 mm)	103	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	132	°C	ISO 306/A, ASTM D1525 ¹
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	220 - 250	°C	
Middle Temperature	240 - 270	°C	
Front Temperature	240 - 270	°C	
Processing (Melt) Temp	250 - 270	°C	

Mold Temperature	70.0 - 90.0	°C
Back Pressure	0.345 - 0.689	MPa
Injection instructions		
Die Temperature: 230 to 270°CInjection Volume: 30 to 80% of injection machine's capacity		
NOTE		
1.	压 力1 (10N)	

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