

PPR ABSPC02

Polycarbonate + ABS
Premier Plastic Resins, Inc.

Message:

PPR ABSPC02 is a polycarbonate acrylonitrile butadiene styrene (PC ABS) product. It can be processed by injection molding and is available in North America.

General Information			
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	52.4	MPa	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus - Tangent	2410	MPa	ASTM D790
Flexural Strength	82.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	530	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	107	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	88.0 - 99.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	238 - 271	°C	
Middle Temperature	249 - 282	°C	
Front Temperature	254 - 288	°C	
Nozzle Temperature	254 - 288	°C	
Processing (Melt) Temp	271 - 304	°C	
Mold Temperature	82.0 - 96.0	°C	
Injection Pressure	55.0 - 97.0	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	41.0 - 83.0	MPa	
Back Pressure	0.00 - 1.00	MPa	
Cushion	6.35 - 12.7	mm	
Injection instructions			

Screw Speed: Slow-ModerateDecompression: 3.81 to 7.6 mm

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Recommended distributors for this material

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

