

VYTEEN PC/ABS 8515

Polycarbonate + ABS

Lavergne Group

Message:

Vyteen PC/ABS 8515 is an enhanced PC/ABS black alloy with balanced impact/stiffness properties designed for injection molding applications

- Features
- High resilience
- Excellent processability
- High Deflection Temperature
- Typical Applications
- Electronics
- Appliances housing
- Electrical components

General Information			
Features	Rigid, good		
	Workability, good		
	Elastic		
Uses	Electrical/Electronic Applications		
	Electrical components		
	Electrical housing		
	Home appliance components		
	Shell		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	0.60 - 0.80	%	ASTM D955
Transverse flow	0.70 - 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	55.0	MPa	ASTM D638
Flexural Modulus ²	2500	MPa	ASTM D790
Flexural Strength ³	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	550	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	120	°C	ASTM D648
Injection	Nominal Value	Unit	

Drying Temperature	105	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	220 - 240	°C
Middle Temperature	240 - 260	°C
Front Temperature	250 - 270	°C
Nozzle Temperature	270 - 275	°C
Processing (Melt) Temp	265 - 275	°C
Mold Temperature	60.0 - 90.0	°C
Injection Rate	Moderate-Fast	
Screw Speed	60 - 90	rpm

Injection instructions

Injection Pressure: Medium Back Pressure: Medium

NOTE

1. 50 mm/min
2. 1.3 mm/min
3. 1.3 mm/min

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