

GLS Blends MS209

Polycarbonate + ABS
GLS Polymers Pvt. Ltd.

Message:
PC /ABS

General Information			
Appearance	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13 to 1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	> 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	> 50.0	MPa	ASTM D638
Tensile Elongation (Yield)	> 15	%	ASTM D638
Flexural Modulus	> 3000	MPa	ASTM D790
Flexural Strength	> 60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	> 400	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	108 to 112	°C	ASTM D648
Vicat Softening Temperature	130 to 132	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	95.0	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	234 to 260	°C	
Mold Temperature	100 to 110	°C	
Injection Pressure	68.0 to 102	MPa	
NOTE			
1.	50 mm/min		

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