

# EXCELLOY CK10P

Polycarbonate + ABS  
Techno Polymer Co, Ltd.

Message:  
EXCELLOY CK10P is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in Asia Pacific or North America.

| General Information                       |                           |                   |                      |
|-------------------------------------------|---------------------------|-------------------|----------------------|
| Agency Ratings                            | JHOSPA Unspecified Rating |                   |                      |
| Processing Method                         | Injection Molding         |                   |                      |
| Physical                                  | Nominal Value             | Unit              | Test Method          |
| Density                                   | 1.10                      | g/cm <sup>3</sup> | ISO 1183, ASTM D1505 |
| Melt Mass-Flow Rate (MFR) (220°C/10.0 kg) | 15                        | g/10 min          | ISO 1133             |
| Molding Shrinkage                         | 0.40 to 0.60              | %                 | ISO 294-4            |
| Hardness                                  | Nominal Value             | Unit              | Test Method          |
| Rockwell Hardness                         |                           |                   |                      |
| R-Scale                                   | 108                       |                   | ASTM D785            |
| R-Scale                                   | 106                       |                   | ISO 2039-2           |
| Mechanical                                | Nominal Value             | Unit              | Test Method          |
| Tensile Strength                          |                           |                   |                      |
| Yield                                     | 49.0                      | MPa               | ASTM D638            |
| Yield                                     | 45.0                      | MPa               | ISO 527-2            |
| Flexural Modulus                          |                           |                   |                      |
| --                                        | 2260                      | MPa               | ASTM D790            |
| --                                        | 1800                      | MPa               | ISO 178              |
| Flexural Strength                         |                           |                   |                      |
| --                                        | 78.5                      | MPa               | ASTM D790            |
| --                                        | 67.0                      | MPa               | ISO 178              |
| Impact                                    | Nominal Value             | Unit              | Test Method          |
| Charpy Notched Impact Strength            | 50                        | kJ/m <sup>2</sup> | ISO 179              |
| Notched Izod Impact                       | 490                       | J/m               | ASTM D256            |
| Thermal                                   | Nominal Value             | Unit              | Test Method          |
| Deflection Temperature Under Load         |                           |                   |                      |
| 0.45 MPa, Unannealed                      | 105                       | °C                | ASTM D648            |
| 0.45 MPa, Unannealed                      | 94.0                      | °C                | ISO 75-2/B           |
| Injection                                 | Nominal Value             | Unit              | Test Method          |
| Drying Temperature                        | 100 to 110                | °C                |                      |
| Drying Time                               | 2.0 to 5.0                | hr                |                      |
| Rear Temperature                          | 220 to 270                | °C                |                      |
| Middle Temperature                        | 220 to 270                | °C                |                      |

|                   |             |    |
|-------------------|-------------|----|
| Front Temperature | 220 to 270  | °C |
| Mold Temperature  | 50.0 to 100 | °C |

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