

# Gebablend 85

Polycarbonate + ABS

geba Kunststoffcompounds GmbH

## Message:

PC/ABS type with high impact unnotched and notched impact strength

Applications:

technical injection molded parts for various sectors (Automotive, Electrical, Electronic, Mechanical)

| General Information                        |                                    |                        |               |
|--------------------------------------------|------------------------------------|------------------------|---------------|
| Features                                   | High Impact Resistance             |                        |               |
| Uses                                       | Automotive Applications            |                        |               |
|                                            | Electrical/Electronic Applications |                        |               |
| Processing Method                          | Injection Molding                  |                        |               |
| Physical                                   | Nominal Value                      | Unit                   | Test Method   |
| Density                                    | 1.16                               | g/cm <sup>3</sup>      | ISO 1183      |
| Melt Volume-Flow Rate (MVR) (260°C/5.0 kg) | 23.0                               | cm <sup>3</sup> /10min | ISO 1133      |
| Molding Shrinkage                          | 0.45 to 0.80                       | %                      |               |
| Mechanical                                 | Nominal Value                      | Unit                   | Test Method   |
| Tensile Modulus                            | 2400                               | MPa                    | ISO 527-2/1/1 |
| Tensile Stress (Yield)                     | 55.0                               | MPa                    | ISO 527-2/50  |
| Tensile Strain (Yield)                     | 5.5                                | %                      | ISO 527-2/50  |
| Impact                                     | Nominal Value                      | Unit                   | Test Method   |
| Charpy Notched Impact Strength             |                                    |                        | ISO 179/1eA   |
| -30°C                                      | 25                                 | kJ/m <sup>2</sup>      |               |
| 23°C                                       | 38                                 | kJ/m <sup>2</sup>      |               |
| Charpy Unnotched Impact Strength           |                                    |                        | ISO 179/1eU   |
| -30°C                                      | No Break                           |                        |               |
| 23°C                                       | No Break                           |                        |               |
| Thermal                                    | Nominal Value                      | Unit                   | Test Method   |
| Heat Deflection Temperature                |                                    |                        |               |
| 0.45 MPa, Unannealed                       | 128                                | °C                     | ISO 75-2/B    |
| 1.8 MPa, Unannealed                        | 109                                | °C                     | ISO 75-2/A    |
| Vicat Softening Temperature                | 128                                | °C                     | ISO 306/B50   |
| Injection                                  | Nominal Value                      | Unit                   |               |
| Drying Temperature - Dry Air Dryer         | 80.0 to 100                        | °C                     |               |
| Drying Time - Dry Air Dryer                | 2.0 to 4.0                         | hr                     |               |
| Suggested Max Moisture                     | 0.050                              | %                      |               |
| Rear Temperature                           | 240 to 260                         | °C                     |               |
| Middle Temperature                         | 250 to 270                         | °C                     |               |

|                        |             |    |
|------------------------|-------------|----|
| Front Temperature      | 250 to 280  | °C |
| Nozzle Temperature     | 250 to 280  | °C |
| Processing (Melt) Temp | 250 to 280  | °C |
| Mold Temperature       | 70.0 to 100 | °C |

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