

PRL PC/ABS-G20

Polycarbonate + ABS
Polymer Resources Ltd.

Message:
PRL PC/ABS-G20 is a Polycarbonate + ABS (PC+ABS) product filled with 20% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: rohs compliant.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	General Purpose		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	2.0 to 12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	72.4	MPa	
Break, 3.18 mm	72.4	MPa	
Flexural Modulus (3.18 mm)	5170	MPa	ASTM D790
Flexural Strength (3.18 mm)	121	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	75	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	127	°C	
1.8 MPa, Unannealed, 3.18 mm	118	°C	
Injection	Nominal Value	Unit	
Drying Temperature	79.4 to 85.0	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	249 to 288	°C	
Middle Temperature	254 to 293	°C	
Front Temperature	260 to 302	°C	
Processing (Melt) Temp	271 to 299	°C	
Mold Temperature	71.1 to 93.3	°C	

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