

TARFLON™ SC-253

Polycarbonate + ABS
Idemitsu Kosan Co., Ltd.

Message:
For plating

General Information			
UL File Number	E48268		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183
Spiral Flow	60.0	cm	Internal Method
Molding Shrinkage			Internal Method
Across Flow : 2.00 mm	0.50 to 0.70	%	
Flow : 2.00 mm	0.50 to 0.70	%	
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.23	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	45.0	MPa	ISO 527-2
Nominal Tensile Strain at Break	95	%	ISO 527-2
Flexural Modulus	1700	MPa	ISO 178
Flexural Stress	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	50	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	100	°C	ISO 75-2/A
CLTE - Flow	6.3E-5	cm/cm/°C	ISO 11359-2
Additional Information	Nominal Value		
ISO Shortname	>PC+ABS<		
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	5.0 to 8.0	hr	
Rear Temperature	250 to 270	°C	
Middle Temperature	250 to 270	°C	
Front Temperature	250 to 270	°C	
Mold Temperature	60.0 to 80.0	°C	
NOTE			
1.	24h		

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