

Technical Data Sheet

Schulblend PC/ABS-1218EFL BK2044(QM)BLK



Polycarbonate + ABS

Product Description

Polycarbonate + ABS, Easy Flow Injection Grade Colors Available Add "R" for Added Release Add "U" for UV Stabilized

Processing Method	Injection Molding
Attribute	Good Flow
Appearance	Colors Available

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (260 °C/5.0 kg)	18	g/10 min	ASTM D1238
Density - Specific Gravity	1.13	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	55.8	MPa	ASTM D638
Flexural Modulus	2260	MPa	ASTM D790
Tensile Elongation at Break	>140	%	ASTM D638
Flexural Strength	86.2	MPa	ASTM D790
Impact			
Notched Izod Impact, (3.18 mm)	640	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	110	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Temperature	82 to 99	°C
Suggested Max Moisture	<0.020	%
Nozzle Temperature	249 to 277	°C
Processing (Melt) Temp	238 to 277	°C
Front Temperature	238 to 271	°C
Middle Temperature	238 to 271	°C
Rear Temperature	232 to 260	°C
Injection Rate	Moderate-Fast	
Back Pressure	<1.03	MPa
Mold Temperature	60 to 82	°C