POLYblend

65H MA5

PC/ABS-blend

polykemi
BRINGS OUT THE BEST IN PLASTICS

Features Low friction

Feature	Value	Unit	Testmethod
PHYSICAL PROPERTIES			
Density	1,12	g/cm³	ISO 1183
MFI at 260°C/5kg	25	g/10min	ISO 1133
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	2300	MPa	ISO 178
Maximum flexural strength	86	MPa	ISO 178
Maximum tensile strength	57	MPa	ISO 527-2
Elongation at break	--	%	ISO 527-2
Elongation at yield	8	%	ISO 527-2
IMPACT PROPERTIES			
Impact strength	--	--	--
Notched Charpy at +23°C	45	kJ/m²	ISO 179
Notched Charpy at -30°C	16	kJ/m²	ISO 179
Unnotched Charpy at +23°C	NB	kJ/m²	ISO 179
Unnotched Charpy at -30°C	NB	kJ/m²	ISO 179
THERMAL PROPERTIES			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	122/121	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	106/100	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	132	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	115	°C	ISO 306
FLAMMABILITY PROPERTIES			
Flammability	--	--	--
GWT at 2 mm	650	°C	IEC 695-2-1
UL94 at 1.6 mm	HB	--	UL94
HARDNESS			
Ball pressure test	105	°C	IEC 60335-1
ADDITIONAL INFORMATION			
Filler content	--	±2%	ISO 3451
Mould shrinkage (with flow)	0,5-0,7	%	ISO 294-4
Mould shrinkage (across flow)	0,5-0,7	%	ISO 294-4

HDT (annealed/unannealed)

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Feature	Value	Unit	Testmethod
PROCESS INSTRUCTIONS			
Drying time	2-8	h	--
Drying temperature	90-100	°C	--
Maximal moisture content	<0,05	%	--
Melt temperature	240-280	°C	--
Mould temperature	70-100	°C	--
Peripherical screw speed	350-550	mm/s	--
Back pressure	60-100	bar	--

HDT (annealed/unannealed)

During production stops, emptying the cylinder is recommended. Leave the screw in its front most position. For polycarbonate it is also recommended to leave the cylinder temperature at 160- 180°C and that the heating on the feeding zone is on. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. For further information, see the material safety datasheet (MSDS).

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