

Properties**S1100(Type G)**

PC/ABS resin (UL94 HB)

Standard

Properties	Test methods	Test conditions	Units	
Mold shrinkage	ASTM D955	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	53
Flexural strength	ISO 178	-	MPa	86
Flexural modulus	ISO 178	-	MPa	2400
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	80
Deflection temperature under load	ISO 75	1.80MPa	deg C	100
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	110
Flammability	UL94	-	-	HB
Density	ISO 1183	-	g/cm3	1.12

Note

- Values are typical, not quality assured.
- UL recognition File No. of Daicel Polymer is E47773.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
4-5hrs 90-110deg C	230-260	240-260	230-250	210-240	50-100	5-20	60-80