

## Technical Data Sheet

### Schulblend PC/ABS-1218EFL BKBLK



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 |
|--------------------------------------------------------|---------------|-------------------|-------------|
| <b>Physical</b>                                        |               |                   |             |
| Melt Flow Rate, (260 °C/5.0 kg)                        | 18            | g/10 min          | ASTM D1238  |
| Density - Specific Gravity                             | 1.13          | g/cm <sup>3</sup> | ASTM D792   |
| <b>Mechanical</b>                                      |               |                   |             |
| 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   |
| <b>Impact</b>                                          |               |                   |             |
| Notched Izod Impact, (3.18 mm)                         | 640           | J/m               | ASTM D256   |
| <b>Thermal</b>                                         |               |                   |             |
| 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    |