

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
<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