




**Product Data Sheet &
General Processing Conditions**

**ESD C 2580 FR
Polycarbonate/ABS Alloy (PC/ABS)
ESD Protection
Electrically Conductive
Flame Retardant**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | English | SI Metric | ASTM TEST |
|----------------------------------------------|----------------|------------------|------------------|
| Specific Gravity | 1.29 | 1.29 | D 792 |
| Molding Shrinkage 1/8 in (3.2 mm) section | 0.0010 in/in | 0.10 % | D 955 |

MECHANICAL

| | | | |
|----------------------------------------------------------|----------------------------|-----------|--------|
| Impact Strength, Izod notched 1/8 in (3.2 mm) section | 1.0 ft-lbs/in | 53 J/m | D 256 |
| unnotched 1/8 in (3.2 mm) section | 6.0 ft-lbs/in | 320 J/m | D 4812 |
| Tensile Strength | 18000 psi | 124 MPa | D 638 |
| Tensile Elongation | 1.5 % | 1.5 % | D 638 |
| Tensile Modulus | 1.75 x 10 ⁶ psi | 12066 MPa | D 638 |
| Flexural Strength | 25000 psi | 172 MPa | D 790 |
| Flexural Modulus | 1.50 x 10 ⁶ psi | 10342 MPa | D 790 |

ELECTRICAL

| | | | |
|---------------------|--------------|--------------|-------|
| Volume Resistivity | < 1E0 ohm.cm | < 1E0 ohm.cm | D 257 |
| Surface Resistivity | < 1E4 ohm/sq | < 1E4 ohm/sq | D 257 |

THERMAL

| | | | |
|--------------------------------------|---------------|--------------|------|
| Ignition Resistance* Flammability | V-0 @ 1/16 in | V-0 @ 1.5 mm | UL94 |
|--------------------------------------|---------------|--------------|------|

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

GENERAL PROCESSING FOR INJECTION MOLDING

| | English | SI Metric |
|--------------------|-------------------|------------------|
| Injection Pressure | 10000 - 15000 psi | 69 - 103 MPa |
| Melt Temperature | 470 - 525 °F | 243 - 274 °C |
| Mold Temperature | 125 - 200 °F | 52 - 93 °C |
| Drying | 4 hrs @ 200 °F | 4 hrs @ 93 °C |
| Moisture Content | 0.02 % | 0.02 % |
| Dew Point | -20 °F | -29 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.