



**Product Data Sheet &
General Processing Conditions**

**2599 X 121803
Polycarbonate/ABS Alloy (PC/ABS)
Flame Retardant
UL94 V-0**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.17	1.17	D 792
Melt Flow Rate @ 250 °C, / 5.0 kg	35.00 - 50.00 g/10 min	35.00 - 50.00 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0040 - 0.0060 in/in	0.40 - 0.60 %	D 955
Water Absorption, 24 hrs @ 23°C	0.150 %	0.150 %	D 570

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	12.0 ft-lbs/in	641 J/m	D 256
unnotched 1/8 in (3.2 mm) section	40.0 ft-lbs/in	2136 J/m	D 4812
Tensile Strength	8000 psi	55 MPa	D 638
Tensile Elongation Break	> 80.0 %	> 80.0 %	D 638
Tensile Modulus	0.37 x 10 ⁶ psi	2551 MPa	D 638
Flexural Strength	12500 psi	86 MPa	D 790
Flexural Modulus	0.40 x 10 ⁶ psi	2758 MPa	D 790
Hardness Rockwell, R	122	122	D 785

ELECTRICAL

Surface Resistivity	> 1E15 ohm/sq	> 1E15 ohm/sq	D 257
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THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	190 °F	88 °C	D 648
@ 66 psi (455 kPa)	205 °F	96 °C	D 648
Ignition Resistance* Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94
Limiting Oxygen Index	30.0 %	30.00 %	D 2863

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