

MRC365D1

Description

MRC365D1, a Flame Retardant Post-Consumer Recycled ABS product for injection molding, contains 10% PCR resin and is designed to carry out black colors with the same physical properties as standard FR ABS, flammability rating of V-0 at 2.0mm. (Early stage of development : The data can be changed as a result of the quality improvement of the products)

Key Features

Flame Retardancy, Recycled ABS (PCR 10%)

Application

Batter Case, PCB Case, Electrical/Electronic Products

Properties	Condition	Method	Unit	MRC365D1
Physical				
Specific Gravity	23°C	ASTM D792		1.17
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	65
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	40
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15 ~
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	64
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2300
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	200
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	130
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	84
Flammability	2.0mm	UL 94		V-0
Flammability	3.0mm	UL 94		V-0

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	70 ~ 80
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	200 ~ 230
Mold Temperature	°C	40 ~ 80
Screw Speed	rpm	30 ~ 60

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.