PC/ABS PC/PBT Compounds
DINABLEND®

Grupo Repol
Engineering plastics

Technical Data Sheet [TDS]

PC/ABS Dinablend Natural

Reference: PCABS1S25 HI HHY-0084

Properties	Unit	Method	Value d.a.m.
Physical			
Relative density	g/cm³	ISO 1183	1,14
Mechanical			
Tensile modulus (1 mm/min)	MPa	ISO 527	2200
Stress at break (50 mm/min)	MPa	ISO 527	48
Strain at yield (50 mm/min)	%	ISO 527	4,5
Strain at break (50 mm/min)	%	ISO 527	>100
Flexural modulus (2 mm/min)	MPa	ISO 178	1800
Flexural strength (2 mm/min)	MPa	ISO 178	65
Charpy notched impact strength (23ºC)	kJ/m²	ISO 179/1eA	50
Charpy notched impact strength (-30ºC)	kJ/m²	ISO 179/1eA	35
Charpy unnotched impact strength (23ºC)	kJ/m²	ISO 179/1eU	NB
Rheological			
Melt flow index M.F.I. (260ºC, 5 kg)	g/10min	ISO 1133	15-20
Thermal			
Heat deflection temperature HDT (1.80 MPa)	ºC	ISO 75-A	105
VICAT softening temperature	ºC	ISO 306-B50	129
Flammability classification (1.6mm)	V0-V1-V2-HB	UL 94	HB
Processing			
Melt temperature range	ºC	-	230 - 270
Recommended mould temperature	ºC	-	60 - 100
Drying temperature	ºC	-	100
Drying time	h	-	2 - 4

Last update: 06/ 2013