

## Technical Data Sheet [TDS]

## PC/ABS Dinablend Natural

Reference: PCABS1S25 HI HHY-0084

Properties	Unit	Method	Value d.a.m.
<b>Physical</b>			
Relative density	g/cm <sup>3</sup>	ISO 1183	1,14
<b>Mechanical</b>			
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 (23°C)	kJ/m <sup>2</sup>	ISO 179/1eA	50
Charpy notched impact strength (-30°C)	kJ/m <sup>2</sup>	ISO 179/1eA	35
Charpy unnotched impact strength (23°C)	kJ/m <sup>2</sup>	ISO 179/1eU	NB
<b>Rheological</b>			
Melt flow index M.F.I. (260°C, 5 kg)	g/10min	ISO 1133	15-20
<b>Thermal</b>			
Heat deflection temperature HDT (1.80 MPa)	°C	ISO 75-A	105
VICAT softening temperature	°C	ISO 306-B50	129
Flammability classification (1.6mm)	V0-V1-V2-HB	UL 94	HB
<b>Processing</b>			
Melt temperature range	°C	-	230 - 270
Recommended mould temperature	°C	-	60 - 100
Drying temperature	°C	-	100
Drying time	h	-	2 - 4

The data submitted here are, to the best of Grupo Repol's knowledge, representative of the range of properties for the listed products, but should not be used to establish process limits or used as the direct basis of design. Colorants or other additives may alter these properties. The data are given for natural grade unless otherwise specified.

Last update: 06/ 2013



