

Ravago Manufacturing Americas Hybrid S470H Acrylonitrile Butadiene Styrene + PC Alloy

Category : Polymer , Thermoplastic , ABS Polymer , Polycarbonate/ABS Alloy, Unreinforced , Polycarbonate (PC)

Material Notes:

Available in North America Flame Retardant RoHS Compliant UL File Number: E157012 Form: Pellets Processing Method: Injection Molding
Information provided by Ravago

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hybrid-S470H-Acrylonitrile-Butadiene-Styrene-PC-Alloy.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.21 g/cc	1.21 g/cc	ASTM D792
Linear Mold Shrinkage, Flow	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	ASTM D955
Melt Flow	8.5 g/10 min @Load 2.16 kg, Temperature 260 °C	8.5 g/10 min @Load 4.76 lb, Temperature 500 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	63.4 MPa	9200 psi	ASTM D638
Elongation at Break	30 %	30 %	ASTM D638
Flexural Strength	82.7 MPa	12000 psi	ASTM D790
Flexural Modulus	2.41 GPa	350 ksi	ASTM D790
Izod Impact, Notched	6.41 J/cm @Thickness 3.17 mm	12.0 ft-lb/in @Thickness 0.125 in	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	124 °C	255 °F	Unannealed; ASTM D648
Flammability, UL94	V-0 @Thickness 1.50 mm	V-0 @Thickness 0.0591 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	249 - 260 °C	480 - 500 °F	
Middle Barrel Temperature	254 - 266 °C	490 - 510 °F	
Front Barrel Temperature	260 - 271 °C	500 - 520 °F	

Processing Properties	Metric	English	Comments
Mold Temperature	71.1 - 93.3 °C	160 - 200 °F	
Drying Temperature	104 - 110 °C	220 - 230 °F	
	@Time 7200 - 14400 sec	@Time 2.00 - 4.00 hour	
Dry Time	<= 10.0 hour	<= 10.0 hour	
Moisture Content	<= 0.040 %	<= 0.040 %	Suggested Maximum
Injection Pressure	5.52 - 11.7 MPa	800 - 1700 psi	
Back Pressure	0.345 - 0.827 MPa	50.0 - 120 psi	
Shot Size	40 - 80 %	40 - 80 %	
Screw Speed	40 - 60 rpm	40 - 60 rpm	

Descriptive Properties	Value	Comments
Injection Rate	Moderate	

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