

Ravago Manufacturing Americas Hybrid S459 ABS + Polycarbonate Alloy

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

Material Notes:

Entec's proprietary products include a full range of compounds in the Nylon 6/6, Nylon 6, ABS, PBT, Polycarbonate, PC/ABS, PC/ASA, PC/PBT, and PPO/PPE resin families. Information provided by Ravago.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hybrid-S459-ABS-Polycarbonate-Alloy.php

Physical Properties	Metric	English	Comments
Density	1.10 g/cc	0.0397 lb/in ³	ASTM D792
Linear Mold Shrinkage	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	0.125 in; ASTM D955
Melt Flow	4.1 g/10 min	4.1 g/10 min	ASTM D1238
	@Load 3.80 kg, Temperature 230 °C	@Load 8.38 lb, Temperature 446 °F	
	5.7 g/10 min	5.7 g/10 min	
	@Load 2.16 kg, Temperature 260 °C	@Load 4.76 lb, Temperature 500 °F	ASTM D1238
	14.8 g/10 min	14.8 g/10 min	
	@Load 3.80 kg, Temperature 260 °C	@Load 8.38 lb, Temperature 500 °F	

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	53.8 MPa	7800 psi	ASTM D638
Elongation at Break	60 %	60 %	ASTM D638
Flexural Yield Strength	68.9 MPa	10000 psi	ASTM D790
Flexural Modulus	2.34 GPa	340 ksi	ASTM D790

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	118 °C	244 °F	Unannealed (0.125 in); ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	95.6 °C	204 °F	Unannealed (0.125 in); ASTM D648
Flammability, UL94	HB	HB	0.0590 in

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	232 - 243 °C	450 - 470 °F	

Processing Properties	Metric	English	Comments
Front Barrel Temperature	238 - 249 °C	460 - 480 °F	
Front Barrel Temperature	243 - 254 °C	470 - 490 °F	
Nozzle Temperature	249 - 260 °C	480 - 500 °F	
Mold Temperature	60.0 - 82.2 °C	140 - 180 °F	
Drying Temperature	104 °C	220 °F	
Dry Time	3 - 4 hour	3 - 4 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Injection Pressure	6.89 - 11.7 MPa	1000 - 1700 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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