

Ravago Manufacturing Americas Hybrid S464 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-S464-ABS-Polycarbonate-Alloy.php

Physical Properties	Metric	English	Comments
Density	1.12 g/cc	0.0405 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	3.2 g/10 min	3.2 g/10 min	ASTM D1238
	@Load 3.80 kg, Temperature 230 °C	@Load 8.38 lb, Temperature 446 °F	
	6.8 g/10 min	6.8 g/10 min	
	@Load 2.16 kg, Temperature 260 °C	@Load 4.76 lb, Temperature 500 °F	ASTM D1238
	15 g/10 min	15 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	57.2 MPa	8300 psi	ASTM D638
Elongation at Break	70 %	70 %	ASTM D638
Flexural Yield Strength	68.9 MPa	10000 psi	ASTM D790
Flexural Modulus	2.34 GPa	340 ksi	ASTM D790
Izod Impact, Notched	6.94 J/cm	13.0 ft-lb/in	73°F, 0.125 in; ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	112 °C	234 °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	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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