

Ravago Manufacturing Americas Hybrid S464LG Acrylonitrile Butadiene Styrene + PC Alloy

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

Material Notes:

Available in North America Good Toughness Low Gloss RoHS Compliant Form: Pellets Processing Method: Injection Molding Automotive

Specifications: Chrysler MS-DB300 CPN4352 Color: Natural, Chrysler MS-DB300 CPN4352 Color: DX9 BLACK Black 056Information

provided by Ravago

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hybrid-S464LG-Acrylonitrile-Butadiene-Styrene-PC-Alloy.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.13 g/cc	1.13 g/cc	ASTM D792
Density	1.13 g/cc	0.0408 lb/in ³	ISO 1183
Linear Mold Shrinkage, Flow	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	ASTM D955 and ISO 294-4
Melt Flow	15 g/10 min @Load 5.00 kg, Temperature 260 °C	15 g/10 min @Load 11.0 lb, Temperature 500 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	51.4 MPa	7450 psi	ISO 527-2
	51.7 MPa	7500 psi	ASTM D638
Elongation at Break	55 %	55 %	ASTM D638
	55 %	55 %	ISO 527-2
Flexural Yield Strength	75.8 MPa	11000 psi	ASTM D790
Flexural Modulus	2.21 GPa	320 ksi	ASTM D790
	2.23 GPa	323 ksi	ISO 178
Izod Impact, Notched	5.34 J/cm	10.0 ft-lb/in	ASTM D256
Izod Impact, Notched (ISO)	37.8 kJ/m ²	18.0 ft-lb/in ²	ISO 180

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	110 °C	230 °F	Unannealed; ASTM D648
	112 °C	234 °F	Unannealed; ISO 75-2/A

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	232 - 243 °C	450 - 470 °F	
Middle Barrel Temperature	238 - 260 °C	460 - 500 °F	
Front Barrel Temperature	243 - 271 °C	470 - 520 °F	
Nozzle Temperature	243 - 271 °C	470 - 520 °F	
Mold Temperature	65.6 - 82.2 °C	150 - 180 °F	
Drying Temperature	104 - 110 °C @Time 7200 - 14400 sec	220 - 230 °F @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 - 12.4 MPa	800 - 1800 psi	
Back Pressure	0.345 - 1.03 MPa	50.0 - 150 psi	
Shot Size	40 - 80 %	40 - 80 %	
Screw Speed	40 - 60 rpm	40 - 60 rpm	

Descriptive Properties	Value	Comments
Injection Rate	Moderate	
Melt-Volume Flow Rate, 260°C/5.0 kg (in3/10 min)	0.854	ISO 1133

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