

Star Plastics PC/ABSQX7004 Molding Grade PC/ABS

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

Material Notes:

Information provided by Star Plastics, Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Star-Plastics-PCABSQX7004-Molding-Grade-PCABS.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.13 g/cc	1.13 g/cc	ASTM D792
Maximum Moisture Content	0.020	0.020	
Linear Mold Shrinkage	0.0040 - 0.0070 cm/cm	0.0040 - 0.0070 in/in	ASTM D955
Melt Flow	10 g/10 min @Load 5.00 kg, Temperature 260 Â°C	10 g/10 min @Load 11.0 lb, Temperature 500 Â°F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	55.2 MPa	8000 psi	ASTM D638
Tensile Modulus	2.28 GPa	330 ksi	ASTM D638
Flexural Yield Strength	82.7 MPa	12000 psi	ASTM D790
Flexural Modulus	2.34 GPa	340 ksi	ASTM D790
Izod Impact, Notched	6.14 J/cm	11.5 ft-lb/in	73Â°F, 0.125 in.; ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	107 Â°C	225 Â°F	unannealed, .125in; ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	238 - 282 Â°C	460 - 540 Â°F	
Middle Barrel Temperature	260 - 288 Â°C	500 - 550 Â°F	
Front Barrel Temperature	260 - 304 Â°C	500 - 580 Â°F	
Nozzle Temperature	260 - 304 Â°C	500 - 580 Â°F	
Melt Temperature	260 - 304 Â°C	500 - 580 Â°F	
Mold Temperature	73.9 - 102 Â°C	165 - 215 Â°F	

Processing Properties	Metric	English	Comments
Dry Time	3 - 4 hour	3 - 4 hour	
Back Pressure	0.172 - 0.689 MPa	25.0 - 100 psi	
Screw Speed	25 - 75 rpm	25 - 75 rpm	

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