PRODUCT INFORMATION

TAROBLEND 45

PC/ABS alloy medium thermal resistance, good flow and mechanical properties, low moisture absorption and good dimensional stability.

ISO short ISO 1043: PC+ABS
Form Pellets

Key Features

- Unfilled
- Designed for injection moulding applications
- Good flowability

Availability

- S: suitable for painting process
- M: low gloss allowing paint-less visible applications
- LP: laser printable
- L: UV stabilized
- All colours
- AS: antistatic

Compliance

- Designed for automotive applications requiring the compliance with the VW TL 522 31 - Type A method.

Process

- INJECTION MOULDING

Application

- Power tools
- Household
- General purpose applications
- Furniture
- Electronic
- Electrical
- Toys
- Sports
- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	> 10E(15)		
Dielectric Strength	IEC 60243-1	kV/mm	24	2 mm	

PRODUCT INFORMATION

TAROBLEND 45

Tracking Resistance (CTI - Method A)	IEC 60112	Volt	550	
PHYSICAL				
Density (+23°C)	ISO 1183	g/cm^3	1,12	
Water Absorption (24h / +23°C)	ISO 62	%	0,2	
Water Absorption at Saturation	ISO 62	%	0,6	
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,7	+23°C - 3,2 mm
Mould Shrinkage (Normal)	Internal method	%	0,4 - 0,7	+23°C - 3,2 mm
Melt Flow Rate (MFR)	ISO 1133	g/10 min	17	260°C - 5 kg
MECHANICAL				
Tensile Modulus	ISO 527-1,2	MPa	2000	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	46	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	30	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2150	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	75	Speed 1 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	450	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	40	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	N.B.	
THERMAL				
Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	125	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	118	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	100	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	
Continuous service temperature (20.000 h)	UL746 B	°C	80	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	6,5x10E(-5)	-30°C /+30°C
FLAMMABILITY				
Flame Behaviour (1,6 mm)	UL94	Class	HB	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	650	

PRODUCT INFORMATION

TAROBLEND 45

Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	< 80	Thickness > 1,5 mm
Oxigen index	ASTM D2863	%	22	

INJECTION MOULDING	**Value**
Drying Temperature (Desiccant Dryer)	80 - 100°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,1 %
Suggested Max Regrind	< 15 %
Melt Temperature	230 - 270°C
Feed Temperature	210°C
Rear Temperature	230°C
Middle Temperature	240°C
Front Temperature	250°C
Nozzle Temperature	260°C
Mould Temperature	50 - 80°C
Injection Rate	Medium to Fast
Injection Pressure	10 - 35 Mpa
Packing Pressure	12 - 40 Mpa
Back Pressure	< 0,4 Mpa
Screw Revolving Speed	50 - 100 rpm
Cushion	> 4 mm
Screw L/D Ratio	16 - 20
Vent Depth	0,02 mm

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.