



PRODUCT INFORMATION

**TAROBLEND 65 X0**

PC/ABS alloy medium-high thermal resistance, flame retardant UL94 V0, good flow and mechanical properties, good dimensional stability.

**ISO short** ISO 1043: PC+ABS FR  
**Form** Pellets  
**UL file** E143048

**Key Features**

- Unfilled
- Good impact - stiffness balance
- Designed for injection moulding applications
- Flame retardant
- Good flowability

**Availability**

- LP: laser printable
- L: UV stabilized
- All colours

**Compliance**

- UL94 V0 approved all colours at 1,7 mm. UL746 B approved.

**Process**

- INJECTION MOULDING

**Application**

- Power tools
- Household
- Electronic
- Electrical

Property	Method	Unit	Value	Condition	State
<b>ELECTRICAL</b>					
Volume Resistivity	IEC 60093	Ohm cm	>10E(15)		
Dielectric Strength	IEC 60243-1	kV/mm	22	2 mm	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	200		
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,20		
Water Absorption (24h / +23°C)	ISO 62	%	0,20		
Water Absorption at Saturation	ISO 62	%	0,60		
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,7		
Mould Shrinkage (Normal)	Internal method	%	0,4 - 0,7		



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Melt Flow Rate (MFR)	ISO 1133	g/10 min	20	260°C - 5 kg
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**MECHANICAL**

Tensile Modulus	ISO 527-1,2	MPa	2500	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	65	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	45	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	50	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2450	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	85	Speed 1 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	450	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	20	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	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	115	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	110	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	
Continuous service temperature	UL746 B	°C	60	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K <sup>-1</sup>	7x10E(-5)	-30°C /+30°C

**FLAMMABILITY**

Flame Behaviour (1,7 mm)	UL94	Class	V0	UL approved
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	960	
Glow Wire Ignition Temperature-GWIT (1,6 mm)	IEC 60695-2-13	°C	775	
Oxygen index	ASTM D2863	%	32	

**INJECTION MOULDING**

	Value
Drying Temperature (Desiccant Dryer)	90 - 110°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,1 %



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Suggested Max Regrind	< 15 %
Melt Temperature	240 - 270°C
Feed Temperature	220°C
Rear Temperature	240°C
Middle Temperature	250°C
Front Temperature	255°C
Nozzle Temperature	260°C
Mould Temperature	50 - 90°C
Injection Rate	Medium to Fast
Injection Pressure	10 - 35 Mpa
Packing Pressure	12 - 40 Mpa
Back Pressure	< 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.