



PRODUCT INFORMATION

TAROBLEND 85 X0

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

ISO short Form 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
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ELECTRICAL

Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>200		
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PHYSICAL

Density (+23°C)	ISO 1183	g/cm ³	1,2		
Water Absorption (24h / +23°C)	ISO 62	%	0,1		
Water Absorption at Saturation	ISO 62	%	0,4		
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,7		
Mould Shrinkage (Normal)	Internal method	%	0,4 - 0,7		

MECHANICAL

Tensile Yield Strength	ISO 527-1,2	MPa	50	Speed 50 mm/min	
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Flexural Modulus	ISO 178	MPa	2100	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	70	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	500	+23°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	20	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	N.B.	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	142	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	135	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	

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	

INJECTION MOULDING

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



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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.