



PRODUCT INFORMATION

TAROBLEND 85

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

ISO short Form ISO 1043: PC+ABS Pellets

Key Features

- Unfilled
- Designed for injection moulding applications

Availability

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

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	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	250		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,15		



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Water Absorption (24h / +23°C)	ISO 62	%	0,10	
Water Absorption at Saturation	ISO 62	%	0,40	
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,7	
Mould Shrinkage (Normal)	Internal method	%	0,4 - 0,7	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	12	260°C - 5 kg

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	2200	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	55	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	60	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2200	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	85	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	380	-30°C
IZOD Notched Impact (+23°C)	ASTM D256	J/m	650	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	42	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	N.B.	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	143	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	136	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	120	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	
Continuous service temperature (20.000 h)	UL746 B	°C	100	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	7,5x10E(-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	750	
Oxygen index	ASTM D2863	%	24	



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INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	80 - 100°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,1 %
Suggested Max Re grind	< 15 %
Melt Temperature	240 - 270°C
Feed Temperature	220°C
Rear Temperature	235°C
Middle Temperature	245°C
Front Temperature	255°C
Nozzle Temperature	265°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. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine or extruder size, part geometry and design.