PRODUCT INFORMATION

TAROBLEND 88 G4

PC/ABS alloy 20% glass fibres reinforced, high stiffness and thermal resistance.

ISO short	ISO 1043: PC+ABS-GF20
Form	Pellets

Key Features

- Good impact - stiffness balance
- Good flowability
- Designed for automotive applications

Availability

- 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	>10exp(15)		
Dielectric Strength	IEC 60243-1	kV/mm	24	2 mm	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	200		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,24 - 1,26		
Filler content	ISO 3451	%	20	750°C - 1 h	

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Water Absorption (24h / +23°C)	ISO 62	%	0,10	
Water Absorption at Saturation	ISO 62	%	0,25	
Mould Shrinkage (Parallel)	Internal method	%	0,2-0,4	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	260°C - 5 kg
MECHANICAL				
Tensile Modulus	ISO 527-1,2	MPa	6000	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	2	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	75	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	5200	Speed 1 mm/min
Flexural Break Strength	ISO 178	MPa	110	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	100	+23°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	10	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	30	
THERMAL				
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	134	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	118	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	4x10exp(-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	
Oxigen index	ASTM D2863	%	24	

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 %

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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	HIGH
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.