PRODUCT INFORMATION

TECNOBLEND B35 G2

ABS/PA alloy 8% glass fibres reinforced combining excellent dimensional stability, very good impact strength, stiffness and chemical resistance with good surface appearance.

ISO short ISO 1043: ABS-PA-GF10
Form Pellets

Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Good surface aspect

Availability

- L: UV stabilized
- All colours

Compliance

- Designed for automotive applications requiring the compliance with the European Directive 2000/53/EC (End-of-Life Vehicle).

Process

- INJECTION MOULDING

Application

- General purpose applications
- Furniture
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,12		
Filler content	ISO 3451	%	8	750°C / 1 h	
Granule Humidity	Internal method	%	<0,10		
Water Absorption at Saturation	ISO 62	%	1,4		
Mould Shrinkage (Parallel)	Internal method	%	0,5	+23°C - 3,2 mm	
Mould Shrinkage (Normal)	Internal method	%	0,8	+23°C - 3,2 mm	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	30	240°C - 10 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	3100	Speed 1 mm/min	

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Elongation at Break	ISO 527-1,2	%	6	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	54	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2850	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	74	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	120	+23°C
IZOD Notched Impact	ASTM D256	J/m	60	-20°C
IZOD Notched Impact	ISO 180/1A	kJ/m^2	5,8	-30°C
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m^2	12	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	11	
CHARPY Notched Impact (-30°C)	ISO 179/1eA	kJ/m^2	5,5	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	180	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	85	120°C / h
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	135	120°C / h
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	6x10exp(-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	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	<100	Thickness 1,6 mm

INJECTION MOULDING	Value
Drying Temperature (Circulating Air Oven)	80 - 90°C
Drying Time (Circulating Air Oven)	1 h
Melt Temperature	250 - 280°C
Feed Temperature	220°C
Rear Temperature	230°C
Middle Temperature	240°C
Front Temperature	245°C

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Nozzle Temperature	255°C
Mould Temperature	50 - 80°C
Injection Rate	MEDIUM

Notes For more information regarding processing and/or mold design you may contact our Technical Service team.