PRELIMINARY DATASHEET

LUVOTECH® PC/ABS 50157

LUVOTECH®
Thermoplastic compounds

PC/ABS Alloy
unreinforced, black

T85

Physical properties		Test method	Specimen	Units	Typical value
Specific gravity		ISO 1183-3		g/cm³	1,14
Mechanical properties at 23°C / 50% rh					
Tensile strength	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	MPa	50
Elongation at maximum force	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	5,0
Elongation at break	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	50
Modulus of elasticity	dry, @1 mm/min	ISO 527	MPTS ISO 3167 A	GPa	2,2
Charpy impact strength, notched	dry	ISO 179 1eA	80x10x4mm	kJ/m²	35
Thermal properties					
Vicat softening temp	VST A	DIN ISO 306	MPTS ISO 3167 A	°C	122
Electrical properties					
Insulation resistance strip electrode	R25	DIN IEC 60167	MPTS ISO 3167 A	Ω	$>10^{12}$
Surface resistance	ROB	DIN IEC 60093	Ronde 60x4mm	Ω	$>10^{12}$

Main features

EFFICIENCY

High dimensionally stable precision parts with low warpage and narrow tolerance range. Impact resistance.

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Recommended processing parameters

Predrying		
It is advisable to predry the granulate with a suitable dryer immediately before processing. The granulate may absorb moisture from the environment.		
Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	95	2 - 5
Processing		
Zone 1	°C	240 - 250
Zone 2	°C	250 - 260
Zone 3	°C	250 - 260
Nozzle	°C	260 - 270
Mold	°C	70 - 100
Melt temperature	°C	260

In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!

Delivery form & storage

Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.

Additional information

During processing the moisture level should not exceed 0.02%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. Processing temperatures above 270°C may very rapidly cause thermal damage and should therefore be avoided. The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application. Please contact us for further information.

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