

Technical Data Sheet [TDS]

PC/ABS Dinablend Black

Reference: PCABS4S20-4321

Properties	Unit	Method	Value d.a.m.
Physical			
Relative density	g/cm ³	ISO 1183	1.13
Mechanical			
Tensile modulus (1 mm/min)	MPa	ISO 527	2400
Stress at yield (50 mm/min)	MPa	ISO 527	52
Strain at yield	%	ISO 527	4
Flexural strength (2 mm/min)	MPa	ISO 178	80
Charpy notched impact strength (23°C)	kJ/m ²	ISO 179/1eA	60
Charpy unnotched impact strength (23°C)	kJ/m ²	ISO 179/1eU	NB
Rheological			
Melt flow index M.F.I. (260°C, 5 kg)	g/10min	ISO 1133	20
Thermal			
VICAT softening temperature	°C	ISO 306-B50	120
Flammability classification (1.6mm)	V0-V1-V2-HB	UL 94	HB
Processing			
Melt temperature range	°C	-	230 - 270
Recommended mould temperature	°C	-	60 - 100
Drying temperature	°C	-	100
Drying time	h	-	2 - 4

The data submitted here are, to the best of Grupo Repol's knowledge, representative of the range of properties for the listed products, but should not be used to establish process limits or used as the direct basis of design. Colorants or other additives may alter these properties. The data are given for natural grade unless otherwise specified.

Last update: 03/ 2015



