Technical Data Sheet

SCHULABLEND® (PC/ABS) M/MB 4302 PG

Polycarbonate + ABS
Engineering Plastics

Product Description			
ABS/PC blend, suitable for electroplating. (Former name: RONFALIN® C110)			
General			
Features	• General Purpose		
Uses	• Audio Tapes	• General Purpose	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.12 g/cm³	1.12 g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	15 g/10 min	15 g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.60 %	0.40 to 0.60 %	
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	319000 psi	2200 MPa	ISO 527-2
Tensile Stress (Yield)	7250 psi	50.0 MPa	ISO 527-2
Tensile Strain (Break)	> 50 %	> 50 %	ISO 527-2
Flexural Modulus	312000 psi	2150 MPa	ISO 178
Flexural Stress	10400 psi	72.0 MPa	ISO 178
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (Area) (73°F (23°C))	19.0 ft·lb/in²	40.0 kJ/m²	ASTM D256
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	235 °F	113 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	203 °F	95.0 °C	ISO 75-2/A
Vicat Softening Temperature			
--	248 °F	120 °C	ISO 306/A50
--	230 °F	110 °C	ISO 306/B50
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flame Rating			UL 94
0.06 in (1.5 mm)	HB	HB	IEC 60695-11-10, -20
0.12 in (3.0 mm)	HB	HB	

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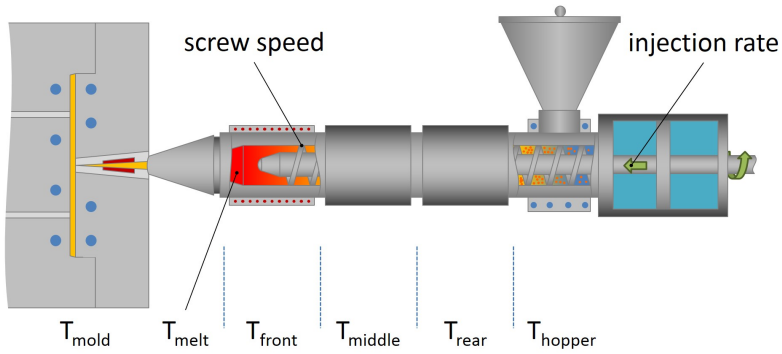

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	212 to 230 °F	100 to 110 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	158 to 212 °F	70 to 100 °C

Notes

These are typical property values not to be construed as specification limits.