

Electrafil® PC/ABS 07001 MB

Techmer Polymer Modifiers - Polycarbonate + ABS

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Electrically Conductive
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.75E+6	psi	ASTM D638
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Strength (Break)	13000	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+4	ohms	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 550	°F
Middle Temperature	520 to 560	°F
Front Temperature	530 to 570	°F
Nozzle Temperature	540 to 580	°F
Processing (Melt) Temp	510 to 575	°F
Mold Temperature	150 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

