

Technical information

TEREZ[®] PC/ABS Blend 2000 GF 20

Heat distortion resistant PC/ABS Blend with 20%GF
reinforce



TECHNICAL DATA SHEET

Product text

For all kind of injection moulding parts with increased requirements of stiffness

Properties	Value	Unit	Test method
Density	1,2500	g/cm ³	ISO 1183
Melt flow index (MFI)	10,00	g/10 min	ISO 1133
MFI Temperature	260	°C	ISO 1133
MFI Load	5,00	kg	ISO 1133
Impact strength Charpy (Notched 23°C), dry	5	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	30	kJ/m ²	ISO 179
Elongation at tear, dry	2	%	ISO 527
Tensile strength at break, dry	75	MPa	ISO 527
Elongation at yield, dry	2,00	%	ISO 527
Tensile stress at yield, dry	75	MPa	ISO 527
Tensile-modulus, dry	6000	MPa	ISO 527
Tensile strength, dry	70	MPa	ISO 527
HDT 0,45 MPa	130	°C	ISO 75
HDT 1,80 MPa	118	°C	ISO 75
Vicat B/50	120	°C	ISO 306
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PC/ABS Blend 2000 GF 20

The processing data sheet provides guidelines about processing as well as pre-drying.

MATERIAL PREPARATION

Storage

Store in a dry place protected from direct sunlight. Avoid all sources of ignition like extreme heat, sparks, or open flame.

Drying

For the manufacturing of mechanically and optically optimal injection molding parts, we recommend following pre-drying conditions according to the table below. If the container is open (wet granules), the drying time can be extended accordingly.

Dry air dryer	
Temperature	100°C
Time	4 hours
Due point	-40°C

Residual moisture	
<= 0.03% (recommended)	

MACHINE REQUIREMENTS

PROCESSING

Basic settings

Temperatures

Processing temperatures	
Hopper	60 - 80°C
Center	250 - 280°C
Nozzle	240 - 270°C

Mold temperature	
Temp.	50 - 80°C

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

Instructions for cleaning

The aggregate can be cleaned by using low MFI polypropylene. You can also use standard cleaning granulate.