

Technical information

TEREZ[®] PC/ABS Blend 3000 GF 20

PC/ABS Blend with 20% glasfibre



TECHNICAL DATA SHEET

Product text

For all kind of injection molding parts with high demand on heat resistance

Properties	Value	Unit	Test method
Density	1,2900	g/cm ³	ISO 1183
Melt flow index (MFI)	20,00	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	7	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	24	kJ/m ²	ISO 179
Tensile-modulus, dry	6500	MPa	ISO 527
Heat conductivity	0,22	W/mK	DIN 52612
Tensile stress at break, dry	93	MPa	ISO 527
Elongation at break, dry	1,50	%	ISO 527
HDT 0,45 MPa	127	°C	ISO 75
HDT 1,80 MPa	116	°C	ISO 75
Vicat B/50	128	°C	ISO 306
CTI	175	V	IEC 60112
Surface resistivity	1E16	Ohm	IEC 60093
Volume resistivity	1E14	Ohm * m	IEC 60093
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Moisture absorption	0,22	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PC/ABS Blend 3000 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
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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.