PRELIMINARY DATASHEET

LUVOTECH® PC/ABS T85 eco BK

LUVOTECH®
Thermoplastic compounds

PC/ABS Alloy
unreinforced, black

Physical properties		Test method	Specimen	Units	Typical value
Specific gravity		ISO 1183-3		g/cm³	1,14
Water absorption	23°C / 24h	ISO 62	MPTS ISO 3167 A	%	<0,2
Mechanical properties at 23°C / 50% rh					
Tensile strength	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	MPa	50
Elongation at maximum force	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	4,5
Modulus of elasticity	dry, @1 mm/min	ISO 527	MPTS ISO 3167 A	GPa	2,2
Charpy impact strength	dry	ISO 179 1eU	80x10x4mm	kJ/m²	NB
Charpy impact strength	dry		80x10x4mm	kJ/m²	NB
Charpy impact strength, notched	dry	ISO 179 1eA	80x10x4mm	kJ/m²	30

Main features

Impact resistance.

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Recommended processing parameters

Predrying		
It is advisable to predry the granulate with a suitable dryer immediately before processing. The granulate may absorb moisture from the environment.		
Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	70 - 100	3 - 5
Processing		
Zone 1	°C	210 - 250
Zone 2	°C	220 - 260
Zone 3	°C	230 - 270
Nozzle	°C	240 - 280
Mold	°C	50 - 100
Melt temperature	°C	270
In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!		
Delivery form & storage		
Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.		
Additional information		
During processing, the moisture level should not exceed 0.02%, otherwise molecular degradation may occur. Suitable heat treatment may increase resistance to the formation of stress cracks. The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application. Please contact us for further information.		

QUACERT DIN EN ISO 9001

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