

<b>Properties for PC/ABS 2011</b>
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Product Name: ReZen PC/ABS 2011
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**Description:** Automotive PC/ABS alloy

**Appearance:** Black

**Processing Methods:** Injection molding profile extrusion

**Application:** Automotive, business equipment, thin-walled applications

Physical Properties	SI	English	Test Method
<b>Specific Gravity</b>	1.14 sp gr	1.14 sp gr	ASTM D792
<b>Melt Flow (230 °C/2.16kg)</b>	20.0/10min	20.0/10min	ASTM D1238
<b>Mold Shrink-Flow: 0.126 in / 3.20 mm</b>	0.005 to 0.007 mm/mm	0.005 to 0.007 in/in	ASTM D955
<b>Flame Rating 0.125</b>	HB	HB	UL 94
Mechanical Properties	SI	English	Test Method
<b>Tensile Strength @ Yield</b>	54 Mpa	7,900 psi	ASTM D638
<b>Tensile Elongation @ Break</b>	145%	145%	ASTM D638
<b>Flexural Modulus</b>	2,317 Mpa	336,000 psi	ASTM D790
<b>Flexural Strength</b>	90 Mpa	13,000 psi	ASTM D790
<b>Izod Impact, Notched (23 °C/73 °F)</b>	587 J/m	11.0 ft-lb/in	ASTM D256
Thermal Properties	SI	English	Test Method
<b>Heat Deflection Temp. @ 66 psi</b>	129 °C	264 °F	ASTM D648
<b>Heat Deflection Temp. @ 264 psi</b>	112 °C	234 °F	ASTM D648
Injection Molding	Value	Units	
<b>Drying Temp.</b>	180-220	°F	
<b>Drying Time</b>	2.0-4.0	hours	
<b>Max. Drying Time</b>	4.0	hours	
<b>Suggested Max. Moisture</b>	0.02	%	
<b>Rear Barrel Temps.</b>	450-500	°F	
<b>Middle Barrel Temps.</b>	455-505	°F	
<b>Front Barrel Temps.</b>	465-525	°F	
<b>Nozzle Temp.</b>	475-525	°F	
<b>Melt (processing) Temps.</b>	475-525	°F	
<b>Mold Temps.</b>	175-200	°F	
<b>Back Pressure</b>	25-100	psi	
<b>Screw Speed</b>	25-75	rpm	

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