

PC Alloy Compounding ABS, AS Compounding

Grade	ASTM Method	Unit	SA122G20	SA122G30	SA131G20	SA131G30	SA132G20	SA132G30	SS201G20	SS201G30	SE801G20	SE801G30
Material			FR-PC/ABS/GF20	FR-PC/ABS/GF30	PC/PBT/GF20	PC/PBT/GF30	FR-PC/PBT/GF20	FR-PC/PBT/GF30	ABS/GF20	ABS/GF30	AS/GF20	AS/GF30
			Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard	Standard
Specific Gravity	D792		1.26	1.35	1.35	1.46	1.34	1.44	1.2	1.29	1.21	1.3
Mold Shrinkage	D955	%	0.3~0.5	0.2~0.4	0.5~0.7	0.4~0.6	0.5~0.7	0.4~0.6	0.2~0.4	0.2~0.4	0.2~0.4	0.2~0.4
Tensile Strength	D638	kgf/cm ²	700	950	930	1100	880	1000	850	900	1100	1250
Elongation	D638	%	8	7	3.5	3.5	3.5	3.5	3	3	1.8	1.7
Flexural Strength	D790	kgf/cm ²	1200	1350	1650	1800	1600	1750	1150	1250	1300	1500
Flexural Modulus	D790	kgf/cm ²	40000	60000	58000	70000	55000	70000	60000	75000	70000	85000
Izod Impact	D256	kgf·cm/cm	9	9	25	29	12	10	8	8	5	5.5
H.D.T.	D648	°C	100	105	118	122	105	108	100	105	100	105
Flammability	UL94		V0	V0	HB	HB	V0	V0	HB	HB	HB	HB

Drying Temp.		°C	90	90	90	90	90	90	90	90	90	90
Drying Time		HR	4	4	4	4	4	4	4	4	4	4
Melt Temp.		°C	230~260	230~260	230~260	230~260	230~260	230~260	220~250	220~250	220~260	220~260
Mold Temp.		°C	80	80	90	90	90	90	80	80	60	60