

Technical Data Sheet

K8264

PC/ABS

PRODUCT DESCRIPTION:

PC/ABS K8264 is a super heat resistance plating grade PC/ABS resin.K8264 is suitable used as handle or other products with high strength and durability.

FEATURES:

- Plating grade
- heat resistance

APPLICATION:

- Handle
- trim

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.12
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.5-0.7
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	47
Flexural Strength	ISO 178	2mm/min	MPa	62
Flexural Modulus	ISO 178	2mm/min	MPa	2000
Notched Charpy Impact Strength	ISO 179-1eA	4J, 23°C	kJ/m ²	46
Notched Charpy Impact Strength	ISO 179-1eA	4J, -30°C	kJ/m ²	30
Unnotched Charpy Impact Strength	ISO 179-1eU	4J, 23°C	kJ/m ²	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	103
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	120
Other Properties				
Flammability	ISO 3795	355×100×3 mm	mm/min	≤80

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		100-110	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
General Guidelines			
Barrel Temperature	Rear	220-230	°C
	Middle	240-250	°C
	Front	255-275	°C
Nozzle		250-270	°C
Melt Temperature		255-275	°C
Mold Temperature		60-85	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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