

REPRO PC/ABS RTX65



BRINGS OUT THE BEST IN PLASTIC RECYCLING

PC/ABS

Features Recycled raw material

Property	Value	Unit	Test method
PHYSICAL PROPERTIES			
Density	1,13	g/cm ³	ISO 1183
MFI at 260°C/5kg	25	g/10min	ISO 1133
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	2300	MPa	ISO 178
Maximum flexural strength	90	MPa	ISO 178
Maximum tensile strength	50	MPa	ISO 527-2
IMPACT PROPERTIES			
Notched Charpy at +23°C	45	kJ/m ²	ISO 179
Notched Charpy at -20°C	--	kJ/m ²	ISO 179
Unnotched Charpy at +23°C	NB	kJ/m ²	ISO 179
Unnotched Charpy at -20°C	NB	kJ/m ²	ISO 179
THERMAL PROPERTIES			
HDT 120°C/h at 455kPa (B)	108	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	95	°C	ISO 75/1
Vicat 50°C/h at 49,05N (B)	110	°C	ISO 306
FLAMMABILITY PROPERTIES			
GWFI at 2 mm	650	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB	--	UL94
ADDITIONAL INFORMATION			
Mould shrinkage (with flow)	0,5- 0,7	%	Polykemi
Mould shrinkage (across flow)	0,5 - 0,7	%	Polykemi
PROCESS INSTRUCTIONS			
Drying time	2-8	h	--
Drying temperature	90-100	°C	--
Melt temperature	240-260	°C	--
Mould temperature	60-100	°C	--
Peripheral screw speed	300-500	mm/s	--
Back pressure	60-100	bar	--

Further material information is available upon request

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardized test specimens in natural color. All information, recommendations and advice, written or verbal, given by an individual company within, or agent affiliated with, The Polykemi Group are according to our knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Companies within, or agent affiliated with, The Polykemi Group can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. We takes no responsibility for any printing errors.

Visiting address
Bronsgatan 8
SE-271 39 YSTAD

+46 (0)411 170 30
rondo@rondoplast.se
www.rondoplast.se

THE POLYKEMI GROUP



Version 1 2020-11-13