

Technical Data Sheet

PCR ABS Regranulate Black

Product Code: 000119

Recycled Content: 100 % PCR (post-consumer)

Product Description:

000119 PCR ABS Regranulate Black comes from post-consumer recycled materials in Asia and is suitable for injection moulding applications. The material is GRS certified.



Physical Property	Value	Units	Test Standard	Test Condition
Tensile Strength	40	MPa	ISO 527-2	50mm/min
Tensile Strain at Break	8	%	ISO 527-2	50mm/min
Flexural Strength	62	MPa	ISO 178	2mm/min
Flexural Modulus	2000	MPa	ISO 178	2mm/min
Izod Notched Impact Strength	12	kJ/m ²	ISO 180	23°C
Temperature of Deflection Under Load	80	°C	ISO 75	1.8MPa
Vicat Softening Temperature	86	°C	ISO 306	50N, 120°C/h
Volume Resistivity	10 ¹⁶	Ω·cm	IEC 60093	-
Dielectric Strength	23	kV/mm	IEC 60243-1	2mm, in oil
Density	1.05	g/cm ³	ISO 1183-1	23°C
MFR	25	g/10min	ISO 1133-1	220°C, 10Kg
Molding Shrinkage	0.4 - 0.7	%	ISO 2577	23°C
Flammability	HB	/		1.5mm - 3.0mm

Typical Processing Conditions

Processing Parameter	Condition	Optimum	Range	Unit
Melt Temp.		220	210 - 240	°C
Barrel Zone Temp.	Rear	190	180 - 205	°C
Barrel Zone Temp.	Center	215	205 - 230	°C
Barrel Zone Temp.	Front	225	215 - 240	°C
Mold Temp.		50	30 - 80	°C
Processing Temp. Upper Limit		250		°C
Injection Speed		Slow to Moderate		
Back Pressure		0 - 1000		KPa
Pre-dry Requirements		80 - 90°C, 2 - 4hr		

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