

C-Clear™ PC/ABS K8252

Product Description: C-Clear™ PC/ABS K8252 is a high impact strength and high heat resistance PC/ABS resin with low VOCs.

C-Clear™ PC/ABS K8252 has been widely used in Auto and Household appliance, such as panel, car lamp and so on.

Properties	Standard	Unit	Condition	Typical Value
Physical				
Density	ISO 1183	g/cm ³	23℃	1.11
Mold Shrinkage	ISO 294	%	23℃	0.5-0.7
Mechanical				
Tensile Strength	ISO 527	MPa	50mm/min	52
Flexural Strength	ISO 178	MPa	2mm/min	65
Flexural Modulus	ISO 178	MPa	2mm/min	2000
Notched Izod Impact, 23℃	ISO 180	kJ/m ²	5.5J	50
Notched Charpy Impact, 23℃	ISO 179	kJ/m ²	4J	52
Notched Charpy Impact, -30℃	ISO 179	kJ/m ²	4J	32
Unnotched Charpy Impact, 23℃	ISO 179	kJ/m ²	4J	NB
Thermal				
Heat Deflection Temp. 1.80MPa Unannealed	ISO 75	℃	120℃/h	95
VICAT	ISO 306	℃	5kg 50℃/h	112
VOCs Property				
TVOC	PV3341	ugC/g	/	<18
Electrical Properties				
Volume Resistivity	IEC 60093	Ohm-cm	/	>1.E+15
Surface Resistivity	IEC 60093	Ohm	/	>1.E+15

Note:

- 1) These are typical property values, not specifications.
- 2) In case of colored products, the values could vary slightly by color.
- 3) Values are measured at 23℃ and in RH of 50% on injection molded specimens.
- 4) UL File No. E65424, E254819.

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Processing Parameters	Typical Value	Unit
Drying Temperature	90-100	°C
Drying Time	4~6	hour
Maximum moisture content	0.02	/%
Barrel Temperature		°C
Rear	210-230	
Middle	240-250	
Front	250-260	
Nozzle	240-250	
Melt Temperature	240-260	°C
Mold Temperature	50-80	°C
Back Pressure	0.3-1.0	MPa
Screw Speed	30-70	rpm
Note: 1)The above data is only for reference. Exact settings have to follow the product,injection machine and mold.		
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