ESTER INDUSTRIES LTD.

Product Data Sheet-Preliminary

ESTOPLAST ZK8002BB11

[PC-ABS] Compound

Product Description

Polycarbonate - Acrylonitrile Butadiene Styrene Unfilled , Black

Product Applications

Electrical & Electronics: Industrial Control components

General

Material Status	•	Commercial : Active		
Filler/Reinforcement	•	Nil		
Forms	•	Pellets		
Additive	•	Mold Release		
RoHS Compliance	•	ROHS compliant		
Features	•	Good Flow	UV Stabilized	High Impact
Appearance/Color	•	Black		
Processing Method	•	Injection molding		

Physical	Typical Value	Unit	Test Method
Specific Gravity	1.13	-	ASTM D792
Mold Shrinkage – Flow	0.6 – 0.7	%	ISO 294-4
Water absorption 24 Hours at room Temperature	0.2	%	ASTM D570

Mechanical	Dry	Unit	Test Method
Tensile Strength at Yield	540	Kg/cm^2	ASTM D-638
Tensile Strain at Break	30	%	ASTM D-638
Flexural Strength	900	Kg/cm^2	ASTM D-790
IZOD Impact Strength			ASTM D-256A
Notch	375	J/m	
Unnotch	NB	J/m	

Thermal	Dry	Unit	Test Method
Vicat Softening Point (Min) at rate – B	105	^oC	ASTM D-648

Flow	Dry	Unit	Test Method
Melt Flow Index	20	G/10 Min	ASTM D-1238

Flammability	Dry	Unit	Test Method
Flammability Classification 3.00mm	HB	Rating	UL 94

Injection Molding – ZK8002BB11

Drying Conditions

Drying Time(hour)	Temperature	Remarks
3-4	90-100°C	Temperature should not be more than 110°C to avoid discoloration Moisture content after drying should be <0.2% Avoid sudden cooling of dry pellet

Injection Molding Temperatures (°C)				
Mold	Melt	Nozzle	Centre	Feed zone
60 – 90	260 – 270	265 -275	265 -275	245 - 255

Physical form and storage

ESTOPLAST ZK is supplied in pellet form. It should be pre-dried as per the guideline mentioned above prior to molding. Standard packing size is 25kg. In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged.

Product Safety

ESTOPLAST ZK is thermally stable up to 350°C and does not give rise to hazardous material due to degradation or evolution of gases and vapors. ESTOPLAST ZK decomposes above 350°C and gives carbon dioxide and water on charring.
For more information on safety, refer individual product MSDS. Available on request.

Note

All information supplied in this publication is based on our current knowledge and experience. The data provided fall within the normal range of product properties and relate only to the specific material designed. The data provided should not be used to establish specification limits or used alone as the basis of design. ESTER assumes no liability and makes no warranties of any kind, expressed or implied, whatsoever in respect of application, processing or use made of aforementioned information or product.