

PRODUCT DATA SHEET

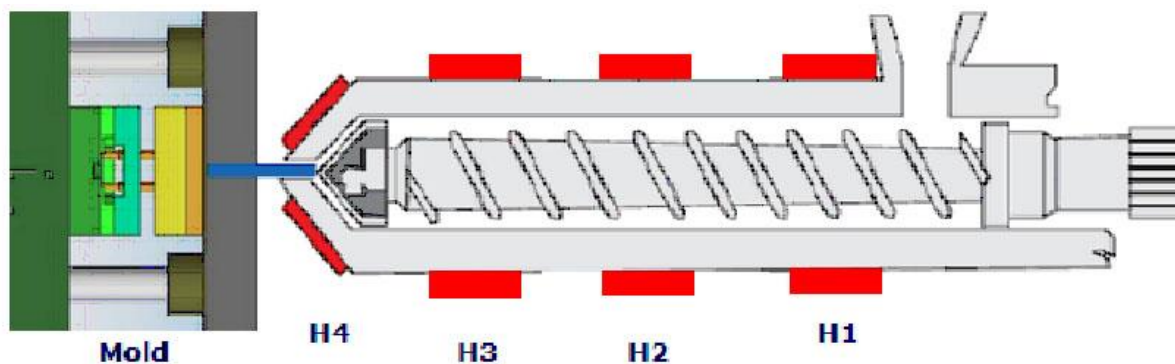
EPA-3500S

■ Description : PC-ABS, High Impact, High stiffness

■ Application : Electrical and Electronics Hosing

General properties	Typical value	Unit	Test method
Specific Gravity	1.22	g/cm ³	ISO 1183
Melt flow rate ,@260°C, 2.16 kgf	18	g/10min	ISO 1133
Mold Shrinkage	0.4 ~ 0.7	% (4~7/1,000)	Polylex method
Ash content	2.1	%	ASTM D5630
Glass content	0	%	ASTM D5630
Max. Water content (After 7 days)	0.12	%	ISO 15512
Mechanical properties			
Izod impact strength, 4 mm notched @+23°C	22	KJ / m ²	ISO 180
Tensile stress, @ yield, 50 mm/min	50	MPa	ISO 527-1.-2
Tensile strain, @ break, 50 mm/min	10	%	ISO 527-1.-2
Flexural strength, @yield, 2.8mm/min	66	MPa	ISO 178
Flexural modulus, @yield, 2.8mm/min	1,900	MPa	ISO 178
Thermal properties			
Deflection temperature @ 1.8 MPa, 4mm	82	°C	ISO-75

PROCESSING GUIDE of EPA-3500S



Parameter Injection Molding		Value	Unit
Drying Temperature		°C	75 ~ 85
Drying Time		Hr	3 ~ 4
Maximum moisture content		%	0.02
Melt Temperature		°C	250 ~ 270
Cylinder Temperature	H4	°C	250 ~ 270
	H3	°C	250 ~ 270
	H2	°C	245 ~ 265
	H1	°C	240 ~ 260
Mold Temperature		°C	60 ~ 80
Back Pressure		MPa	0.3 ~ 0.7
Screw rotating speed		rpm	40 ~ 80