

Technical Data Sheet

HCB9230

PC/PBT

PRODUCT DESCRIPTION:

PC/PBTHCB9230 is a high flow and high heat resistance PC/PBT alloyresin, offering high impact and good chemical resistance.

FEATURES:

- High impact
- Good chemical resistance

APPLICATION:

- Automobile bumper guard
- Side-step

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.20
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.6-0.9
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	59
Elongation at Break	ISO 527	50mm/min	%	110
Flexural Strength	ISO 178	2mm/min	MPa	73
Flexural Modulus	ISO 178	2mm/min	MPa	2200
Notched Izod Impact	ISO 180	5.5J, 23°C	kJ/m ²	60
Notched Izod Impact	ISO 180	5.5J, -30°C	kJ/m ²	34
Unnotched Izod Impact	ISO 180	5.5J, 23°C	kJ/m ²	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	105
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	122
Other Properties				
Flammability	ISO 3795	355x100x3 mm	mm/min	≤80

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		100-110	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
General Guidelines			
Barrel Temperature	Rear	230-260	°C
	Middle	240-270	°C
	Front	240-270	°C
Nozzle		245-265	°C
Melt Temperature		240-270	°C
Mold Temperature		50-80	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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