

LOTTE CHEMICAL

AF-3200

PC/ABS/GF alloy resin

General information

Description

20% glass-fiber reinforced PC/ABS, easy mold release
Non-brominated, non-chlorinated flame retardant
Optimum combination of high modulus and impact strength

Applications

Electric housings, etc.

Typical properties¹

	Test method	Typical value	Unit
Physical			
Melt Flow Index, 300°C, 1.2 kg	ASTM D1238	-	g/10 min
Specific Gravity	ASTM D792	1.3	
Mold Shrinkage	ASTM D955	0.1~0.3	%
Mechanical			
Tensile Strength, yield, 50 mm/min	ASTM D638	950	kg _f /cm ²
Tensile Elongation, break, 50 mm/min	ASTM D638	> 4	%
Flexural Strength, yield, 10 mm/min	ASTM D790	1,400	kg _f /cm ²
Flexural Modulus, 10 mm/min	ASTM D790	54,000	kg _f /cm ²
IZOD Impact Strength, notched, 23°C, 1/8"	ASTM D256	10	kg _f ·cm/cm
notched, 23°C, 1/4"	ASTM D256	-	kg _f ·cm/cm
notched, -30°C, 1/8"	ASTM D256	-	kg _f ·cm/cm
Thermal			
Heat Distortion Temp. 4.6 kg _f /cm ²	ASTM D648	-	°C
18.6 kg _f /cm ²	ASTM D648	120	°C
Vicat Softening Temp. Rate B/50	ASTM D1525	-	°C
Flammability			
V-0	Lotte Chemical Method	1.5	mm

Notes

ISO 9001, 14001, TS 16949

¹ Typical properties : these are not to be construed as specifications.

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Processing guides¹

	Typical value	Unit
Drying condition		
Drying temperature	90 ~ 100	°C
Drying time	4	hr
Maximum moisture content	0.02	%
Injection molding		
Melt temperature	280 ~ 300	°C
Nozzle temperature	270 ~ 290	°C
Barrel	Rear zone	280 ~ 300
	Middle zone	270 ~ 290
	Front zone	260 ~ 280
Hopper temperature	60 ~ 80	°C
Mold temperature	60 ~ 80	°C



Recycling

Sprues and runners can be reground with virgin resin within the ratio of 20%. Care must be taken to ensure that the regrind is free from impurities and regrind should not be used in applications where impact performance and/or agency compliance are required.

Notes

ISO 9001, 14001, TS 16949

¹ Processing guides : Typical processing parameters are noted. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.

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