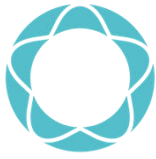


Technical Data Sheet

Polymaker™ PC-ABS

www.polymaker.com

V5.1



Polymaker™
PC-ABS

Polymaker™ PC-ABS is a PC/ABS polymer blend which offers excellent toughness and heat resistance while displaying good surface finish and good compatibility with metal plating.

PHYSICAL PROPERTIES

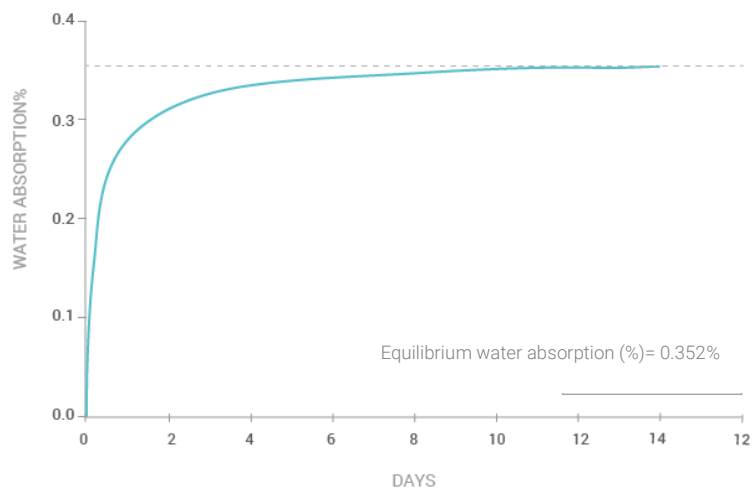
Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.1 g/cm ³ at 23°C
Melt index	260°C, 5 kg	11-17 g/10min
Light transmission	N/A	N/A
Flame retardancy	N/A	N/A

CHEMICAL RESISTANCE DATA

Property	Testing Method
Effect of weak acids	Not resistant
Effect of strong acids	Not resistant
Effect of weak alkalis	Slight resistant
Effect of strong alkalis	Not resistant
Effect of organic solvent	Not resistant
Effect of oils and grease	No data available

MOISTURE ABSORPTION CURVE

Polymaker PC-ABS
70%RH - 23°C



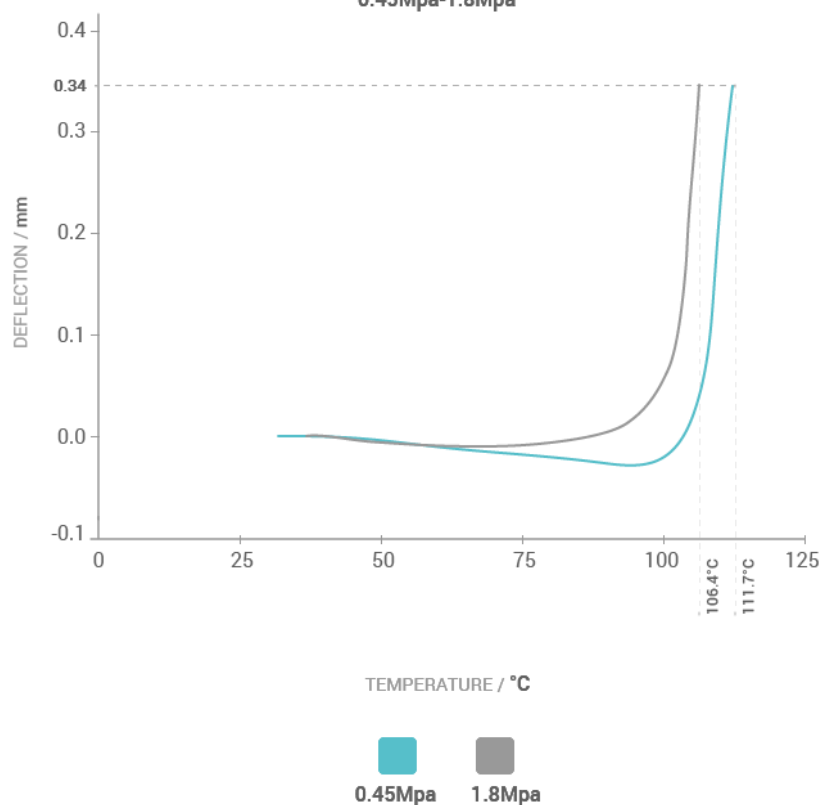
THERMAL PROPERTIES

Property	Testing Method	Typical Value
Glass transition temperature	DSC, 10°C/min	109 °C
Melting temperature	DSC, 10°C/min	N/A
Crystallization temperature	DSC, 10°C/min	N/A
Decomposition temperature	TGA, 20°C/min	N/A
Vicat softening temperature	ISO 306, GB/T 1633	135 °C
Heat deflection temperature	ISO 75 1.8MPa	106.4 °C
Heat deflection temperature	ISO 75 0.45MPa	111.7 °C
Thermal conductivity	N/A	N/A
Heat shrinkage rate	N/A	N/A

HDT CURVE

Polymaker™ PC-ABS

0.45Mpa-1.8Mpa



MECHANICAL PROPERTIES

Property	Testing Method	Typical Value
Young's modulus (X-Y)	ISO 527, GB/T 1040	1835 ± 65 MPa
Young's modulus (Z)		1677 ± 94 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	39.9 ± 1.0 MPa
Tensile strength (Z)		22.9 ± 1.2 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	4.2 ± 0.3 %
Elongation at break (Z)		1.5 ± 0.1 %
Bending modulus (X-Y)	ISO 178, GB/T 9341	2081 ± 106 MPa
Bending modulus (Z)		N/A
Bending strength (X-Y)	ISO 178, GB/T 9341	66.3 ± 0.9 MPa
Bending strength (Z)		N/A
Charpy impact strength (X-Y)	ISO 179, GB/T 1043	25.8 ± 1.3 kJ/m ²
Charpy impact strength (Z)		N/A
Low temperature impact strength (X-Y)	ISO 179-1/1eA:2010, -30°C	13 ± 2 kJ/m ²
Low temperature impact strength (Z)	ISO 179-1/1eA:2010, -30°C	1.5 ± 0.2 kJ/m ²

RECOMMENDED PRINTING CONDITIONS

* Based on 0.4 mm nozzle and Simplify 3D v.4.0. Printing conditions may vary with different nozzle diameters

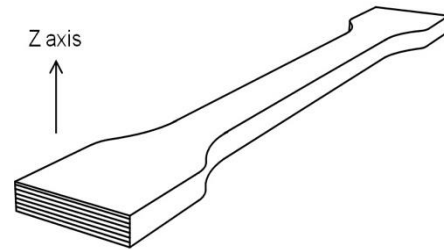
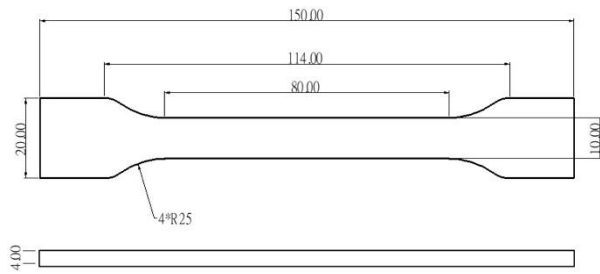
Parameter	
Nozzle temperature	250 – 270 (°C)
Build surface material	Any surface
Build surface treatment	PVA glue or MAGIGOO PC
Build plate temperature	90 - 105 (°C)
Cooling fan	OFF
Printing speed	30-50 (mm/s)
Raft separation distance	0.2 (mm)
Retraction distance	1 (mm)
Retraction speed	20 (mm/s)
Environmental temperature	90-100 (°C)
Threshold overhang angle	45 (°)
Recommended support material	PolyDissolve™ S2

Note:

- When printing with Polymaker™ PC-ABS it is recommended to use an enclosure. For large part it is recommended to use a heated chamber.
- It is recommended to anneal the printed part right after the printing process to release the residual internal stress. Annealing settings: 90°C for 2h

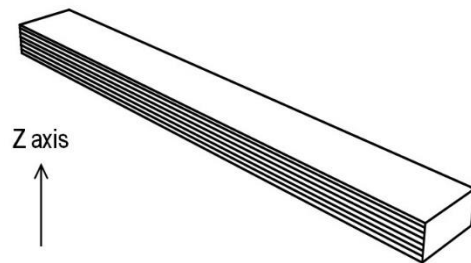
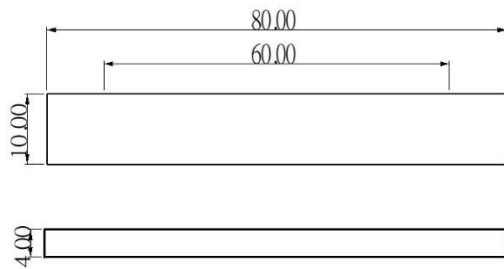
TENSILE TESTING SPECIMEN

ISO 527, GB/T 1040



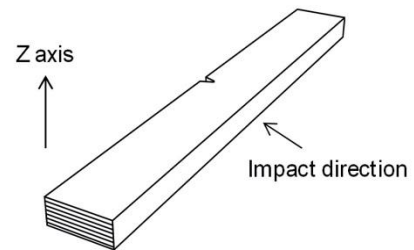
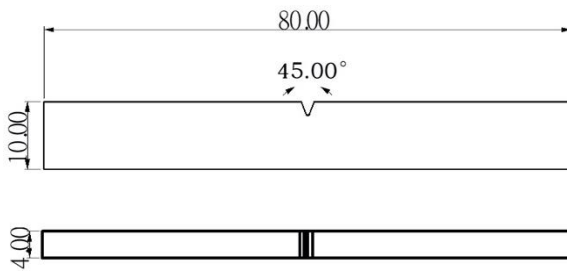
FLEXURAL TESTING SPECIMEN

ISO 178, GB/T 9341



IMPACT TESTING SPECIMEN

ISO 179, GB/T 1043



HOW TO MAKE SPECIMENS

*All specimens were conditioned at room temperature for 24h prior to testing

Printing temperature	260 °C
Bed temperature	105 °C
Shell	2
Top & bottom layer	4
Infill	100%
Environmental temperature	90°C
Cooling fan	OFF

DISCLAIMER:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of Polymaker materials for the intended application. Polymaker makes no warranty of any kind, unless announced separately, to the fitness for any use or application. Polymaker shall not be made liable for any damage, injury or loss induced from the use of Polymaker materials in any application.