

Wonderloy PC540 (B1000)

Acrylonitrile Styrene Butadiene/Polycarbonate

Wonderloy PC540 (B1000) is a high heat modified halogen free Flame retardant PC/ABS blend. It has a very good balance of properties and is suitable for applications where strength and a V0 rating at 1.6mm is required.

Physical Properties	Typical Value	Unit	Test Method based on
Density	1170	Kg/m ³	ISO 1183
Water absorption (23°C, sat)	0.60	%	ISO 62
Moisture absorption (23°C, 50% RH)	0.20	%	ISO 62
Mould shrinkage	0.4-0.7	%	ISO 294
Melt Flow (260°C / 2.16 kg)	20	g/10 min	ISO 1133
Flammability (1.5mm)	V0		UL94
Flammability (2.0 mm)	5VB		UL94

All data given are typical product data and do not represent minimum values.
The actual value may vary depending on colour and additives.

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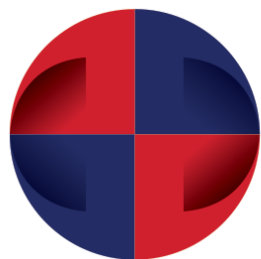
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POLYMER COMPOUNDERS LIMITED

B1000 Wonderloy PC540

Mechanical Properties	Typical Value	Unit	Test Method based on
Tensile Strength at Yield (50mm/min)	61	MPa	ISO 527
Elongation at Break	45	%	ISO 527
Tensile Modulus (1mm/min)	2500	MPa	ISO 527
Flexural Modulus	2400	MPa	ISO 527
Flexural Strength	87	MPa	ISO 178
Izod Notched Impact (RT)	40	kJ/m ²	ISO 180/1A
Charpy Notched Impact (RT)	41	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact (RT)	NB	kJ/m ²	ISO 179/1eU
Rockwell hardness	118	R	ISO 2039-2
Puncture Energy	49.33	J	ISO 6632-2

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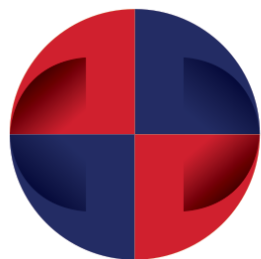
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Thermal Properties	Typical Value	Unit	Test Method based on
CTE linear	7.0E-05	1/°C	ISO 11359-2 (Parallel)
HDT (0.46 MPa)	102	°C	ISO 75/Ae
HDT (1.8 MPa)	97	°C	ISO 75/Ae
Vicat Softening point (B/50)	105	°C	ISO 306

Processing Properties	Typical Value	Unit
Melt Temperature	250	°C
Mould Temperature	70	°C
Injection Velocity	60.0	mm/s
Drying Time	2 to 4	hr
Drying Temperature	90	°C

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