

Technical data

KEBALLOY 3D 10000 PC/ABS

KEBALLOY 3D 10000 PC/ABS is a special compound for 3D effect painting (three-dimensional hologram-like decoration) based on PC/ABS with optimized notched impact strength, e.g. for decorative applications in automotive interiors.

Polymer: PC/ABS

ISO designation: PC/ABS-MED

Productgroup: Compounds for 3D effect painting

Brief description of the product family:

The trade name KEBALLOY stands for polymer blends with a special focus on decorative surfaces. The range includes electroplated chrome types, as well as paintable materials. KEBALLOY 3D is a system of materials and painting processes to achieve a 3D effect paint finish.

Properties:

amorphous, dimensionally stable, paintable, impact resistant

Typical areas of application:

Controls, Actuating elements, Housing, Handles, Sports & Leisure Articles, Trim

Industries:

Automotive, Electrical and electronics industry, Household appliances, Optics, Sports & Recreation

Physical properties

Density in kg/m ³ ISO 1183-1	1310.00
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Mechanical properties

E-modulus in MPa ISO 527-1	2500
Breaking stress in MPa ISO 527-1	50.0
Elongation at break in % ISO 527-1	41.0
Impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eU	268.0
Notched impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eA	15.0

Rheological properties

Shrinkage in flow direction in % ISO 294-4	0.60
Shrinkage transverse to the flow direction in % ISO 294-4	0.55

Thermal properties

Heat deflection temperature HDT (1.80 MPa) in °C ISO 75-1/-2	102.0
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Processing instructions:**Pre-drying:**

Dryer type: dry air dryer

Temperature: 100°C

Drying time: 3-4 h

Residual moisture content: < 0,02%.

Recommended basic settings:

Melt temperature: 250 – 280°C

Mold temperature: 90 °C

Injection speed: slow – medium (avoid high shear)

Machine selection:

Screw: Wear-protected 3-zone screw with non-return valve

Nozzle: Open nozzle

Injection unit: The selected barrel capacity should not exceed 2 – 3 shots to avoid thermal material damage.

Legal notices:

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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