

## Technical Data Sheet

# Polymaker™ PC-ABS

[www.polymaker.com](http://www.polymaker.com)

V5.4



## 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 <sup>3</sup> 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

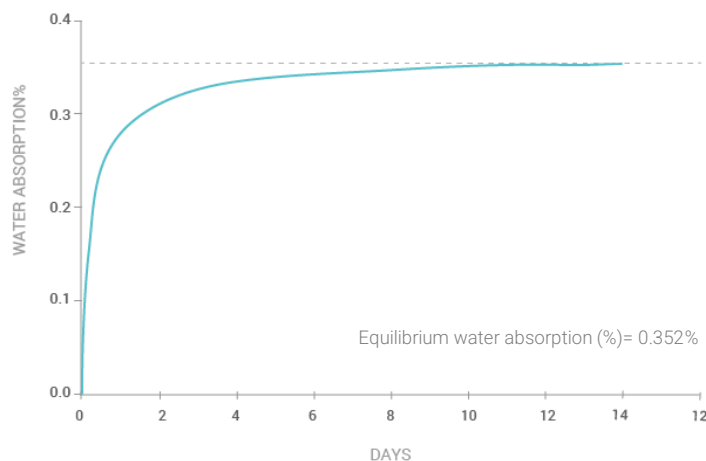
Property	Typical Value
Effect of weak acids	Good
Effect of strong acids	Poor
Effect of weak alkalis	Fair
Effect of strong alkalis	Poor
Effect of oils and grease	Good

**Note:**

- Good: Material may get minor attack after long periods of storage with chemical at ambient temperature
- Fair: Material can be used for short time contact with chemical at ambient temperature
- Poor: Material becomes unstable on contact with chemical at ambient temperature

### MOISTURE ABSORPTION CURVE

Polymaker PC-ABS  
70%RH - 23°C

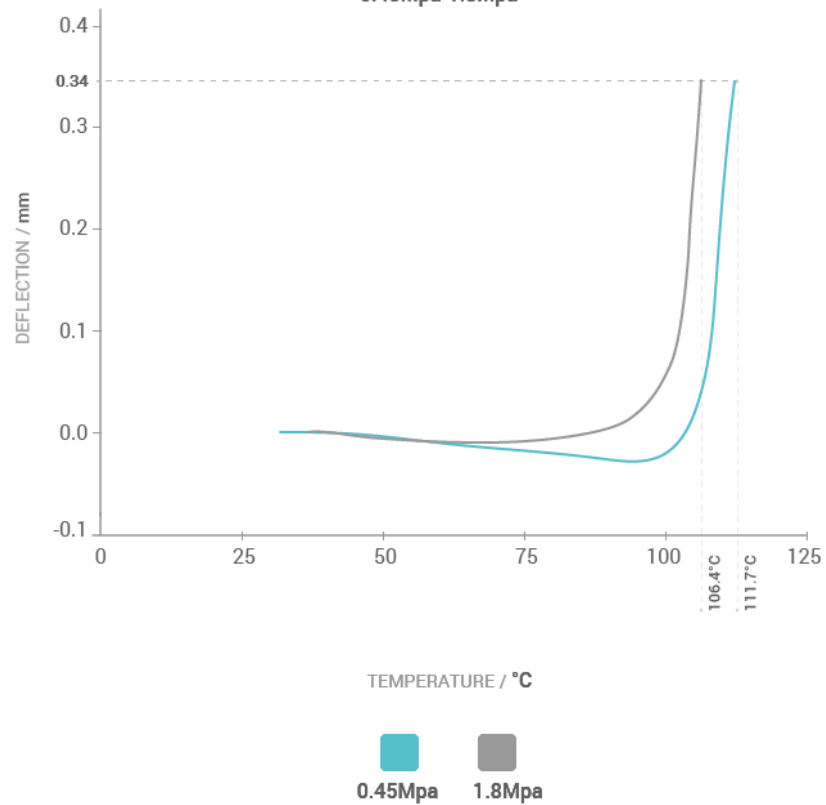


## THERMAL PROPERTIES

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 °C
Heat deflection temperature	ISO 75 0.45MPa	112 °C

## 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
Notched Charpy impact strength (X-Y)	ISO 179, GB/T 1043	25.8 ± 1.3 kJ/m <sup>2</sup>
Notched Charpy impact strength (Z)		N/A
Low temperature impact strength (X-Y)	ISO 179-1/1eA:2010, -30°C	13 ± 2 kJ/m <sup>2</sup>
Low temperature impact strength (Z)	ISO 179-1/1eA:2010, -30°C	1.5 ± 0.2 kJ/m <sup>2</sup>

## RECOMMENDED PRINTING CONDITIONS

Parameter	
Nozzle temperature	250 – 270 (°C)
Build surface treatment	Texture PEI (Glue when needed)
Build plate temperature	90 – 105 (°C)
Cooling fan	OFF
Printing speed	50 - 250 (mm/s)
Retraction distance	1 - 3 (mm)
Retraction speed	20 - 40 (mm/s)
Closure Chamber	Needed (90-100°C)
Recommended support material	-
Drying setting	75°C for 6h
Annealing setting	90°C for 2h

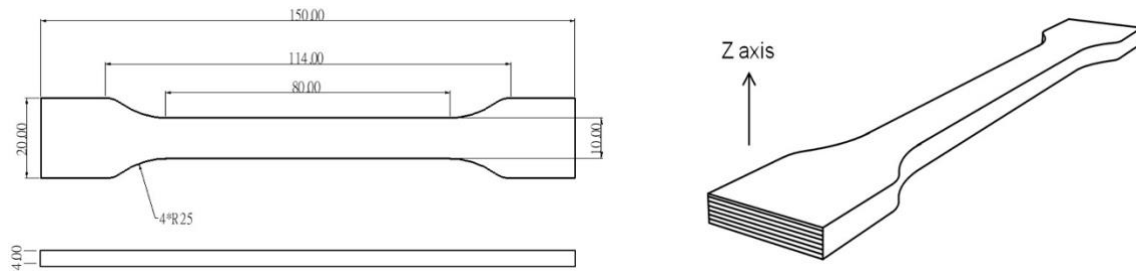
\* Based on 0.4 mm nozzle. Printing conditions may vary with different nozzle diameters

### 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

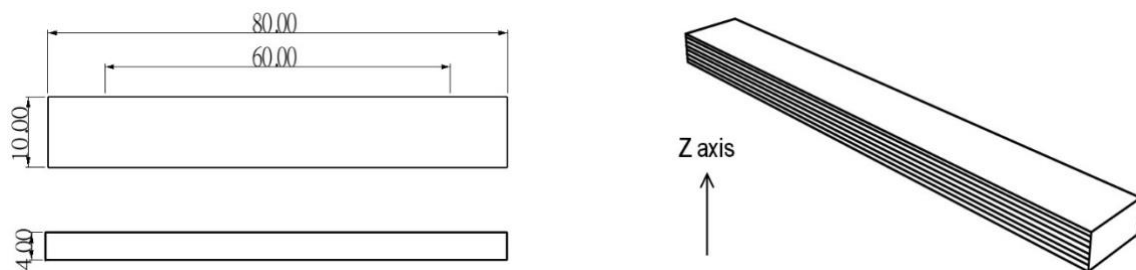
## TENSILE TESTING SPECIMEN

ISO 527, GB/T 1040



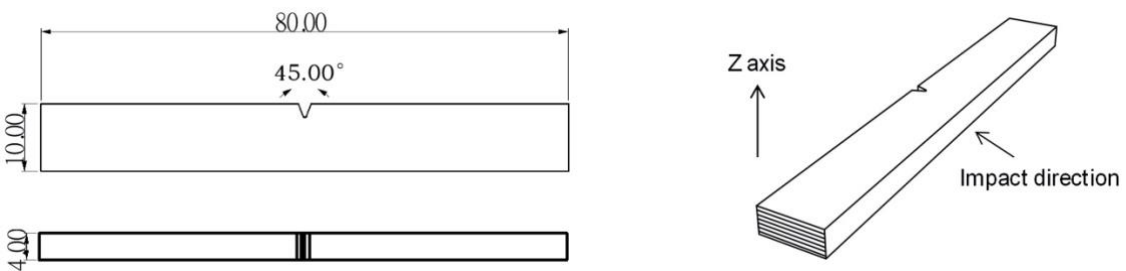
## FLEXURAL TESTING SPECIMEN

ISO 178, GB/T 9341



## IMPACT TESTING SPECIMEN

ISO 179, GB/T 1043



## HOW TO MAKE SPECIMENS

Printing temperature	260 °C
Bed temperature	100 °C
Shell	2
Top & bottom layer	3
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.