



PC-ABS (polycarbonate-ABS) is one of the most widely used industrial thermoplastics. PC-ABS offers the most desirable properties of both materials - the superior mechanical properties and heat resistance of PC and the excellent features of ABS. PC-ABS blends are commonly used in automotive, electronics and telecommunications applications. Additionally, a PC-ABS part manufactured on a FDM mc™ series system is 5-60 percent stronger than a part made on previous FDM systems. When combined with a Stratasys FDM system, PC-ABS gives you Real Parts™ for conceptual prototyping, design verification, and direct digital manufacturing.

Mechanical Properties <sup>1</sup>	Test Method	Imperial	Metric
Tensile Strength (Type 1, 2"/min)	ASTM D638	5,900 psi	41 MPa
Tensile Modulus	ASTM D638	278,000 psi	1,917 MPa
Tensile Elongation	ASTM D638	6%	6%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	9,800 psi	68 MPa
Flexural Modulus	ASTM D790	280,000 psi	1,931 MPa
Flexural Elongation	ASTM D790	70%	70%
IZOD Impact, notched (Method A, 23°C)	ASTM D256	3.7 ft-lb/in	196 J/m
IZOD Impact, un-notched (Method A, 23°C)	ASTM D256	9 ft-lb/in	481 J/m

Thermal Properties <sup>3</sup>	Test Method	Imperial	Metric
Heat Deflection Temp (HDT), 66 psi	ASTM D648	230°F	110°C
Heat Deflection Temp (HDT), 264 psi	ASTM D648	205°F	96°C
Vicat Softening	ASTM D1525	234°F	112°C
Coefficient of Thermal Expansion	-----	4.10E-5 in/in F	-----
Glass Transition Temp (Tg)	DMA (SSYS)	257°F	125°C
Melt Point	-----	Not Applicable <sup>2</sup>	Not Applicable <sup>2</sup>

Other <sup>3</sup>	Test Method	Value
Specific Gravity	ASTM D792	1.20
Density	ASTM D792	0.0397 lb/in <sup>3</sup>
UL 94 Flame Class	UL94	HB 0.85mm
Rockwell Hardness	ASTM D785	R110
Dielectric S (kV/mm)	IEC 60112	35.0
Dielectric C (@100 Hz)	IEC 60250	3.1
Dielectric C (@1 Mhz)	IEC 60250	3.0

► See reverse for system availability.

The information presented are typical values intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. End-use material performance can be impacted (+/-) by, but not limited to, part design, end-use conditions, test conditions, etc. Actual values will vary with build conditions. Tested parts were built on FDM 400mc @ 0.10" (0.254 mm) slice. Product specifications are subject to change without notice.

<sup>1</sup> Build orientation is on side long edge. <sup>2</sup> Due to amorphous nature, material does not display a melting point. <sup>3</sup> Literature value unless otherwise noted.

System Availability	Layer Thickness Capability	Support Structure	Color
FDM 360mc FDM 400mc	0.013 inch (0.330 mm) 0.010 inch (0.254 mm) 0.007 inch (0.178 mm) 0.005 inch (0.127 mm)	Soluble Supports	■ Black

For more information about Stratasys systems and materials, contact your representative at +1 888.480.3548 or visit [www.stratasys.com](http://www.stratasys.com)

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