

PRODUCT INFORMATION

Material: PC/ABS Alloy **Effective Date:** July-04
Grade: PC/ABS-G10
Description: General Purpose, 10% Glass Filled

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate	2-10	g/10 min	ASTM D1238
Specific Gravity	1.20		ASTM D792
Mold Shrinkage	3-6	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	8,700	psi	ASTM D638
Tensile Strength, Yield	9,400	psi	ASTM D638
Flexural Strength	16,000	psi	ASTM D790
Flexural Modulus	580	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	1.5	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	NA	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	256	°F	ASTM D648
HDT @ 264 psi	240	°F	ASTM D648
Flammability			
UL File Number, USA	not listed		
UL 94 rating			

* All physical, mechanical and thermal testing conducted on 1/8-inch thick, un-pigmented, test samples. Nylon grades are tested dry as molded(DAM) and foam grades tested with un-foamed parts.

TYPICAL PROCESSING CONDITIONS

Processing Method: Injection Molding			
Drying Temperature	175-185	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	520-570	°F	
Mold Temperature	160-200	°F	
Front Zone	500-575	°F	
Middle Zone	490-560	°F	
Rear Zone	480-550	°F	

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