

PRODUCT INFORMATION

Material: PC/ABS Alloy
Grade: PC/ABS-GP1
Description: General Purpose

Effective Date: June-03

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate 250C/5kg	3-14	g/10 min	ASTM D1238
Specific Gravity	1.15		ASTM D792
Mold Shrinkage	5-7	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	8,200	psi	ASTM D638
Tensile Strength, Yield	8,400	psi	ASTM D638
Flexural Strength	12,000	psi	ASTM D790
Flexural Modulus	330	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	10.0	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	320	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	235	°F	ASTM D648
HDT @ 264 psi	210	°F	ASTM D648
Flammability			
UL File Number, USA	not listed		
UL 94 rating		HB (0.125 in)	
		HB (0.0625 in)	

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

Nylon grades are

TYPICAL PROCESSING CONDITIONS

Processing Method: Injection Molding

Drying Temperature	170-180	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	525-575	°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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