



2079 Center Square Road
Logan Township, NJ 08085

TECHNICAL DATA AND PROCESS SHEET

POLYCARBONATE/ABS ALLOY

INSTRUC PCABS

TYPICAL PROPERTIES

| <u>PROPERTY</u> | <u>VALUE</u> | <u>UNIT</u> | <u>METHOD</u> |
|-----------------------------|--------------|-------------|---------------|
| PHYSICAL | | | |
| SPECIFIC GRAVITY | 1.22 | - | ASTM D792 |
| MOLD SHRINKAGE, FLOW 0.125" | 0.5-0.7 | % | |
| MECHANICAL | | | |
| TENSILE STRENGTH, BRK | 8,200 | psi | ASTM D638 |
| TENSILE ELONGATION | 5-7 | % | ASTM D638 |
| FLEXURAL MODULUS | 350,000 | psi | ASTM D790 |
| IZOD IMPACT, NOTCHED | 11.8 | ft-lb/in | ASTM D256 |
| IZOD IMPACT, UNNOTCHED | >41 | ft-lb/in | ASTM D256 |
| ELECTRICAL | | | |
| VOLUME RESISTIVITY | >1exp17 | Ohm-cm | ASTM D257 |
| PROCESSING | | | |
| DRYING TEMPERATURE | 200 | °F | |
| DRYING TIME | 3-4 | hrs | |
| MAX MOISTURE CONTENT | 0.02 | % | |
| MELT TEMPERATURE | 475-510 | °F | |
| MOLD TEMPERATURE | 125-180 | °F | |
| BACK PRESSURE | 50-100 | psi | |
| SCREW SPEED | 40-70 | rpm | |
| VENT DEPTH | 0.001-0.002 | in | |

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