



2079 Center Square Road
Logan Township, NJ 08085

TECHNICAL DATA AND PROCESS SHEET

**VERY HIGH FLOW, MOLD RELEASE POLYCARBONATE/ABS ALLOY
(LOCKED MEDICAL FORMULATION)**

INSTRUC PCABSVHFMRMD

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.22	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.5-0.7	%	ASTM D955
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 D4812
ELECTRICAL			
VOLUME RESISTIVITY	>10 ¹⁷	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	

12/22/10 DJV

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