

Diamaloy Abspc 9902 LM 1402 Black

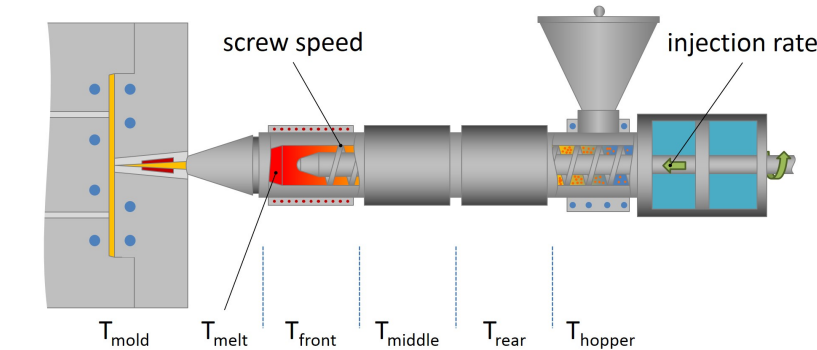
Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

General			
Features	• Laser Markable		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.12	1.12 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 Kg)	20 g/10 min	20 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ² (Yield)	12500 psi	86.2 MPa	ASTM D638
Tensile Elongation (Break)	> 120 %	> 120 %	ASTM D638
Flexural Modulus	330000 psi	2280 MPa	ASTM D790
Flexural Strength ³ (Break)	12500 psi	86.2 MPa	ASTM D790A
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 In (3.18 Mm)	12 ft·lb/in	640 J/m	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed, 0.125 In (3.18 Mm)	265 °F	129 °C	



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	194 to 212 °F	90 to 100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	446 to 500 °F	230 to 260 °C
Middle Temperature	455 to 509 °F	235 to 265 °C
Front Temperature	460 to 522 °F	238 to 272 °C
Nozzle Temperature	460 to 522 °F	238 to 272 °C
Processing (Melt) Temp	460 to 522 °F	238 to 272 °C
Mold Temperature	104 to 212 °F	40 to 100 °C
Back Pressure	50.0 to 150 psi	0.345 to 1.03 MPa

Notes

- ¹ Procedure A
- ² 2.0 in/min (51 mm/min)
- ³ Method I (3 point load), Type I

Notes

These are typical property values not to be construed as specification limits.

