

Diamaloy Asapc GLY 130

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

General			
Additive	• UV Stabilizer		
Agency Ratings	• EC 1907/2006 (REACH)	• EU 2002/96/EC (WEEE)	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.14	1.14 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°c/5.0 Kg)	35 g/10 min	35 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ² (Yield)	8900 psi	61.4 MPa	ASTM D638
Flexural Modulus ³	362000 psi	2500 MPa	ASTM D790B

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (0.125 In (3.18 Mm))	8.0 ft·lb/in	430 J/m	ASTM D256A

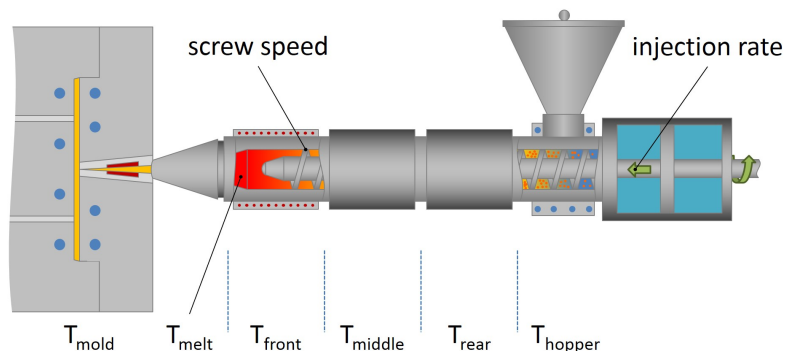
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-scale)	116	116	ASTM D785

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed, 0.250 In (6.35 Mm)	218 °F	103 °C	
264 Psi (1.8 Mpa), Annealed, 0.250 In (6.35 Mm)	250 °F	121 °C	
Vicat Softening Temperature	279 °F	137 °C	ASTM D1525 ⁴
CLTE - Flow (-22 To 176°F (-30 To 80°c))	3.8E-5 in/in/°F	6.8E-5 cm/cm/°C	ASTM D696



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	440 to 500 °F	227 to 260 °C
Middle Temperature	450 to 509 °F	232 to 265 °C
Front Temperature	450 to 520 °F	232 to 271 °C
Nozzle Temperature	450 to 520 °F	232 to 271 °C
Processing (Melt) Temp	450 to 520 °F	232 to 271 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Fast	Fast
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa

Notes

- ¹ Procedure A
- ² 2.0 in/min (51 mm/min)
- ³ Method I (3 point load), 0.050 in/min (1.3 mm/min)
- ⁴ Loading 1 (10 N)

