

Diamaloy Asapc GLY 130 GF10

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

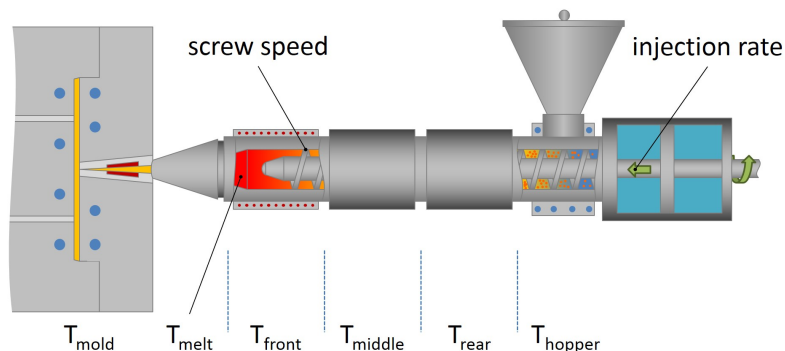
General			
Additive	• UV Stabilizer		
Agency Ratings	• EC 1907/2006 (REACH)	• EU 2002/96/EC (WEEE)	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.25	1.25 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ² (265°C/5.0 Kg)	17 g/10 min	17 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Flexural Modulus ³	425000 psi	2930 MPa	ASTM D790B
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (0.125 In (3.18 Mm))	2.3 ft·lb/in	120 J/m	ASTM D256A
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)	235 °F	113 °C	



Diamaloy Asapc GLY 130 GF10

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 200 °F	82 to 93 °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	446 to 500 °F	230 to 260 °C
Middle Temperature	450 to 509 °F	232 to 265 °C
Front Temperature	455 to 522 °F	235 to 272 °C
Nozzle Temperature	428 to 522 °F	220 to 272 °C
Processing (Melt) Temp	428 to 522 °F	220 to 272 °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 This is an experimental grade only.

² Procedure A

³ Method I (3 point load), 0.050 in/min (1.3 mm/min)

