

Diamaloy Asapc 938

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

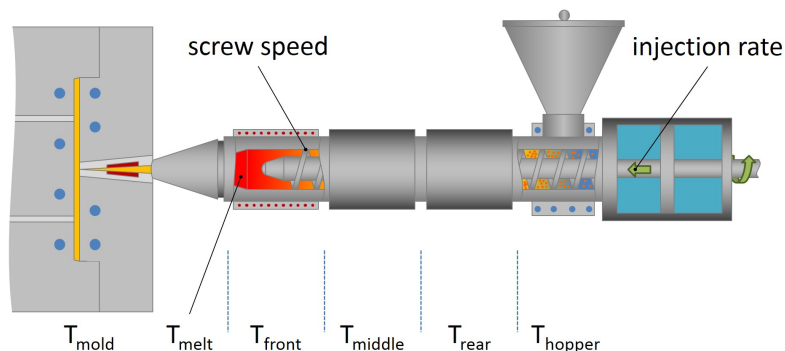
General			
Additive	• UV Stabilizer		
Agency Ratings	• EC 1907/2006 (REACH)	• EU 2002/96/EC (WEEE)	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.11	1.11 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 Kg)	50 g/10 min	50 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus ²			ASTM D638
73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	363000 psi	2500 MPa	
Tensile Strength ²			ASTM D638
Yield, 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	7420 psi	51.2 MPa	
Tensile Elongation			ASTM D638
Break, 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	40 %	40 %	
Flexural Modulus - Tangent ³			ASTM D790B
73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	359000 psi	2480 MPa	
Flexural Strength ⁴			ASTM D790
73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	11300 psi	78.2 MPa	
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256A
73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	7.0 ft·lb/in	370 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), Injection Molded	178 °F	81.1 °C	
Vicat Softening Temperature	237 °F	114 °C	ASTM D1525



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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	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 Procedure A

² Type I, 2.0 in/min (51 mm/min)

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

⁴ 0.050 in/min (1.3 mm/min)

