

**InStruc® PCABSVHFMRMD**  
 Americhem - Polycarbonate + ABS

**General Information**
**Product Description**

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

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Mold Release		
Features	• Good Dimensional Stability	• High Flow	
	• Good Mold Release	• Lubricated	
Uses	• Closures	• Engineering Parts	• Medical/Healthcare Applications
	• Connectors	• Housings	• Surgical Instruments
	• Electrical/Electronic Applications	• Industrial Parts	
Forms	• Pellets		
Processing Method	• Injection Molding		

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	365000	psi	ASTM D638
Tensile Strength	8300	psi	ASTM D638
Tensile Elongation (Yield)	4.0 to 6.0	%	ASTM D638
Flexural Modulus	400000	psi	ASTM D790
Flexural Strength	14500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	12	ft-lb/in	ASTM D256
Unnotched Izod Impact	> 41	ft-lb/in	ASTM D4812
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	
0.12 in		HB	

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	200	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Processing (Melt) Temp	475 to 510	°F
Mold Temperature	125 to 180	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

