

Technical Data Sheet

Diamaloy Abspc 750

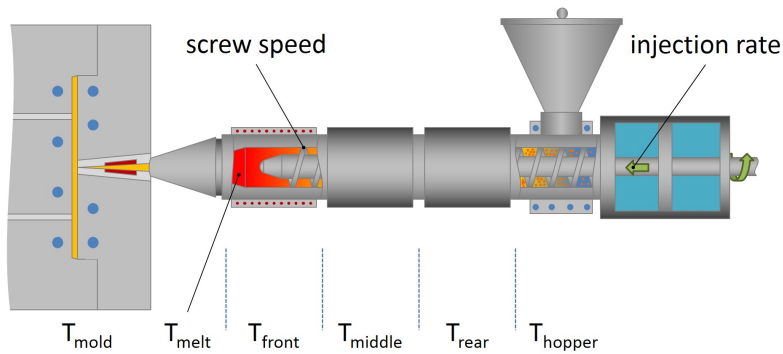
Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

General			
Additive	• Flame Retardant		
Features	• Flame Retardant	• Halogen Free	
UL File NumberUsa	• E150937		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.17	1.17 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (230°C/3.8 Kg)	18 g/10 min	18 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ² (Yield)	8930 psi	61.6 MPa	ASTM D638
Tensile Elongation ² (Yield)	4.5 %	4.5 %	ASTM D638
Flexural Modulus ³	375000 psi	2590 MPa	ASTM D790B
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (0.125 In (3.18 Mm))	12 ft·lb/in	640 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, 0.125 In (3.18 Mm)	190 °F	87.8 °C	
Vicat Softening Temperature	235 °F	113 °C	ASTM D1525 ⁴
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating			UL 94
0.06 In (1.5 Mm)	V-0	V-0	
0.12 In (3.0 Mm)	V-0	V-0	
0.08 In (2.0 Mm)	5VB	5VB	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature - Desiccant Dryer	180 to 210 °F	82 to 99 °C
Drying Time - Desiccant Dryer	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	400 to 440 °F	204 to 227 °C
Middle Temperature	400 to 460 °F	204 to 238 °C
Front Temperature	420 to 480 °F	216 to 249 °C
Mold Temperature	120 to 160 °F	49 to 71 °C
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 Rate B (120°C/h), Loading 1 (10 N)

Notes

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