

Opticarb 1000LG Plus

The Materials Group - Polycarbonate + ABS

General Information

Product Description

Enhanced Low Gloss PC/ABS

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Low Gloss
Uses	• Automotive Applications • General Purpose
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	17	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	326000	psi	ISO 527-1
Tensile Stress (Yield)	7400	psi	ISO 527-2
Tensile Strain (Break)	68	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°F)	24	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	216	°F	ASTM D648
Vicat Softening Temperature	250	°F	ISO 306/B

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220 to 230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	480 to 540	°F
Middle Temperature	490 to 540	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	500 to 540	°F
Processing (Melt) Temp	500 to 540	°F
Mold Temperature	100 to 180	°F

Notes

¹ Typical properties: these are not to be construed as specifications.

