**Technical Data Sheet**

# *Diamaloy Abspc* 9902 LM 1402 Black

Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

| General | |
|---|---|
| Features | • Laser Markable |
| Processing Method | • Injection Molding |

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.12 | 1.12 g/cm³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) [1] (265°c/5.0 Kg) | 20 g/10 min | 20 g/10 min | ASTM D1238 |
| **Mechanical** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Tensile Strength [2] (Yield) | 12500 psi | 86.2 MPa | ASTM D638 |
| Tensile Elongation (Break) | > 120 % | > 120 % | ASTM D638 |
| Flexural Modulus | 330000 psi | 2280 MPa | ASTM D790 |
| Flexural Strength [3] (Break) | 12500 psi | 86.2 MPa | ASTM D790A |
| **Impact** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Notched Izod Impact | | | ASTM D256 |
| 73°f (23°c), 0.125 In (3.18 Mm) | 12 ft·lb/in | 640 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) | 265 °F | 129 °C | |

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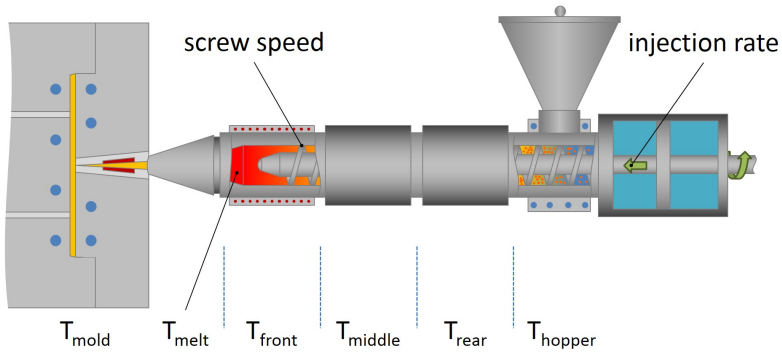


| Injection | Nominal Value (English) | Nominal Value (SI) |
|---|---|---|
| Drying Temperature | 194 to 212 °F | 90 to 100 °C |
| Drying Time | 2.0 to 4.0 hr | 2.0 to 4.0 hr |
| Suggested Max Moisture | 0.02 % | 0.02 % |
| Suggested Shot Size | 40 to 70 % | 40 to 70 % |
| Rear Temperature | 446 to 500 °F | 230 to 260 °C |
| Middle Temperature | 455 to 509 °F | 235 to 265 °C |
| Front Temperature | 460 to 522 °F | 238 to 272 °C |
| Nozzle Temperature | 460 to 522 °F | 238 to 272 °C |
| Processing (Melt) Temp | 460 to 522 °F | 238 to 272 °C |
| Mold Temperature | 104 to 212 °F | 40 to 100 °C |
| Back Pressure | 50.0 to 150 psi | 0.345 to 1.03 MPa |

**Notes**

[1] Procedure A

[2] 2.0 in/min (51 mm/min)

[3] Method I (3 point load), Type I

**Notes**

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