Technical Data Sheet

Diamaloy ABSPC 7901P 1002 UVNAT

Polycarbonate + ABS

Product Description

Diamaloy ABSPC 7901P 1002 UVNAT is a Polycarbonate + ABS material and is typically used in Injection Molding applications. Features include: High Impact Resistance.

Processing Method	Injection Molding
Attribute	High Impact Resistance
Forms	Pellets

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (265 °C/5.0 kg, Procedure A)	8.7	g/10 min	ASTM D1238
Density - Specific Gravity	1.06	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield, (51 mm/min)	40.0	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min, Tangent)	2010	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C, 3.18 mm)	430	J/m	ASTM D256
Hardness			
Rockwell Hardness, (R-Scale)	110		ASTM D785
Thermal			
Vicat Softening Temperature, (Loading 1 (10 N))	112	°C	ASTM D1525
Deflection Temperature Under Load Unannealed (264 psi), (3.18 mm)	78.9	°C	ASTM D648
UL Information			
Flame Rating, (1.5 mm)	HB		UL 94
UL File Number, (USA)	E150937		

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	90 to 100	°C
Suggested Max Moisture	0.02	%
Nozzle Temperature	238 to 272	°C
Processing (Melt) Temp	238 to 272	°C
Front Temperature	238 to 272	°C
Suggested Shot Size	40 to 70	%
Middle Temperature	235 to 265	°C
Rear Temperature	230 to 260	°C
Back Pressure	0.345 to 1.03	MPa
Mold Temperature	40 to 100	°C