

Technical Data Sheet

Diamaloy Asapc 938

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

General		
Additive	• UV Stabilizer	
Agency Ratings	• EC 1907/2006 (REACH)	• EU 2002/96/EC (WEEE)
RoHS Compliance	• RoHS Compliant	
Forms	• Pellets	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.11	1.11 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 Kg)	50 g/10 min	50 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus ² 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	363000 psi	2500 MPa	ASTM D638
Tensile Strength ² Yield, 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	7420 psi	51.2 MPa	ASTM D638
Tensile Elongation Break, 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	40 %	40 %	ASTM D638
Flexural Modulus - Tangent ³ 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	359000 psi	2480 MPa	ASTM D790B
Flexural Strength ⁴ 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	11300 psi	78.2 MPa	ASTM D790

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.125 In (3.18 Mm), Injection Molded	7.0 ft·lb/in	370 J/m	ASTM D256A

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 Psi (1.8 Mpa), Unannealed, 0.125 In (3.18 Mm), Injection Molded	178 °F	81.1 °C	ASTM D648
Vicat Softening Temperature	237 °F	114 °C	ASTM D1525

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	446 to 500 °F	230 to 260 °C
Middle Temperature	450 to 509 °F	232 to 265 °C
Front Temperature	455 to 522 °F	235 to 272 °C
Nozzle Temperature	428 to 522 °F	220 to 272 °C
Processing (Melt) Temp	428 to 522 °F	220 to 272 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Fast	Fast
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 0.050 in/min (1.3 mm/min)