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Technical Data Sheet

Diamaloy ASAPC GLY 130.1785

Polycarbonate + ASA

Product Description

Diamaloy ASAPC GLY 130.1785 is a Polycarbonate + ASA material.

Forms	Pellets
Additive	UV Stabilizer

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (265 °C/5.0 kg, Procedure A)	35	g/10 min	ASTM D1238
Density - Specific Gravity	1.14	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield, (51 mm/min)	61.4	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min, Procedure B, Method I (3 point load))	2500	MPa	ASTM D790
Impact			
Notched Izod Impact, (3.18 mm, Method A)	430	J/m	ASTM D256
Hardness			
Rockwell Hardness, (R-Scale)	116		ASTM D785
Thermal			
Vicat Softening Temperature, (Loading 1 (10 N))	137	°C	ASTM D1525
Deflection Temperature Under Load Annealed (264 psi), (6.35 mm)	121	°C	ASTM D648
Deflection Temperature Under Load Unannealed (264 psi), (6.35 mm)	103	°C	ASTM D648
Coefficent of Linear Thermal Expansion (CLTE), Flow, (-30 to 80 °C)	6.8E-5	cm/cm/°C	ASTM D696

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	80 to 85	°C
Suggested Max Moisture	0.1	%
Nozzle Temperature	232 to 271	°C
Processing (Melt) Temp	232 to 271	°C
Front Temperature	232 to 271	°C
Suggested Shot Size	40 to 70	%
Middle Temperature	232 to 265	°C
Rear Temperature	227 to 260	°C
Injection Rate	Fast	
Back Pressure	0.517 to 1.03	MPa
Mold Temperature	40 to 80	°C