

## TECHNICAL DATA AND PROCESS SHEET

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### POLYCARBONATE/ABS ALLOY

#### INSTRUC PCABS

#### TYPICAL PROPERTIES

| <u>PROPERTY</u>             | <u>VALUE</u> | <u>UNIT</u> | <u>METHOD</u> |
|-----------------------------|--------------|-------------|---------------|
| <b>PHYSICAL</b>             |              |             |               |
| SPECIFIC GRAVITY            | 1.22         | -           | ASTM D792     |
| MOLD SHRINKAGE, FLOW 0.125" | 0.5-0.7      | %           |               |
| <b>MECHANICAL</b>           |              |             |               |
| TENSILE STRENGTH, BRK       | 8,200        | psi         | ASTM D638     |
| TENSILE ELONGATION          | 5-7          | %           | ASTM D638     |
| FLEXURAL MODULUS            | 350,000      | psi         | ASTM D790     |
| IZOD IMPACT, NOTCHED        | 11.8         | ft-lb/in    | ASTM D256     |
| IZOD IMPACT, UNNOTCHED      | >41          | ft-lb/in    | ASTM D256     |
| <b>ELECTRICAL</b>           |              |             |               |
| VOLUME RESISTIVITY          | >1exp17      | Ohm-cm      | ASTM D257     |
| <b>PROCESSING</b>           |              |             |               |
| DRYING TEMPERATURE          | 200          | °F          |               |
| DRYING TIME                 | 3-4          | hrs         |               |
| MAX MOISTURE CONTENT        | 0.02         | %           |               |
| MELT TEMPERATURE            | 475-510      | °F          |               |
| MOLD TEMPERATURE            | 125-180      | °F          |               |
| BACK PRESSURE               | 50-100       | psi         |               |
| SCREW SPEED                 | 40-70        | rpm         |               |
| VENT DEPTH                  | 0.001-0.002  | in          |               |

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