

Technical Data Sheet

Diamaloy PC/ABS-1003 BKBLK



Polycarbonate + ABS

Product Description

Polycarbonate + ABS, Extrusion / General Purpose Injection Grade
Colors Available
Add "R" for Added Release
Add "U" for UV Stabilized

Processing Method	Extrusion; Injection Molding
Appearance	Colors Available
Application	General Purpose

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/3.8 kg)	3.0	g/10 min	ASTM D1238
Density - Specific Gravity	1.13	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	53.8	MPa	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Tensile Elongation at Break	>120	%	ASTM D638
Flexural Strength	82.7	MPa	ASTM D790
Impact			
Notched Izod Impact			
(23 °C, 3.18 mm)	530	J/m	ASTM D256
(-30 °C, 3.18 mm)	320	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	116	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	90 to 100	°C
Nozzle Temperature	238 to 272	°C
Processing (Melt) Temp	238 to 272	°C
Front Temperature	238 to 272	°C
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