

Technical Data Sheet

Diamaloy ASAPC GLY 130 GF10 50583 UVGRY



Polycarbonate + ASA

Product Description

Diamaloy ASAPC GLY 130 GF10 50583 UVGRY 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)	17	g/10 min	ASTM D1238
Density - Specific Gravity	1.25	g/cm³	ASTM D792
Mechanical			
Flexural Modulus, (1.3 mm/min, Procedure B, Method I (3 point load))	2930	MPa	ASTM D790
Impact			
Notched Izod Impact, (3.18 mm, Method A)	120	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi), (6.35 mm)	113	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	82 to 93	°C
Suggested Max Moisture	0.1	%
Nozzle Temperature	220 to 272	°C
Processing (Melt) Temp	220 to 272	°C
Front Temperature	235 to 272	°C
Suggested Shot Size	40 to 70	%
Middle Temperature	232 to 265	°C
Rear Temperature	230 to 260	°C
Injection Rate	Fast	
Back Pressure	0.517 to 1.03	MPa
Mold Temperature	40 to 80	°C