

DIAMALLOY ABSPC 9902 LM 1402 Black

Polycarbonate + ABS
Network Polymers, Inc.

Message:
DIAMALLOY ABSPC 9902 LM 1402 Black is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in North America.

General Information			
Features	Laser Markable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 kg)	20	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	86.2	MPa	ASTM D638
Tensile Elongation (Break)	> 120	%	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength ³ (Break)	86.2	MPa	ASTM D790A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	129	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 70	%	
Suggested Max Regrind	30	%	
Rear Temperature	230 to 260	°C	
Middle Temperature	235 to 265	°C	
Front Temperature	238 to 272	°C	
Nozzle Temperature	238 to 272	°C	
Processing (Melt) Temp	238 to 272	°C	
Mold Temperature	40.0 to 100	°C	
Back Pressure	0.345 to 1.03	MPa	
NOTE			
1.	Procedure A		
2.	51 mm/min		
3.	Method I (3 point load), Type I		

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