

DIAMALLOY ABSPC 7801

Polycarbonate + ABS
Network Polymers, Inc.

Message:

DIAMALLOY ABSPC 7801 is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in North America. Characteristics include:
REACH Compliant
RoHS Compliant
WEEE Compliant
Heat Resistant
Impact Resistant

General Information			
Features	High Heat Resistance		
	High Impact Resistance		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 kg)	29	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	2320	MPa	ASTM D638
Tensile Strength ³ (Yield)	40.9	MPa	ASTM D638
Flexural Modulus - Tangent ⁴ (3.18 mm)	2020	MPa	ASTM D790
Flexural Strength ⁵ (5.0% Strain,3.18 mm)	66.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	550	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.18 mm	106	°C	ASTM D1525 ⁶
1.8 MPa, Unannealed, 6.35 mm	110	°C	
Vicat Softening Temperature	137	°C	
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. Type I, 51 mm/min
3. Type I, 51 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. Rate B (120°C/h), Loading 1 (10 N)

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