



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® ABS 1250R Natural

General Purpose, Medium Impact, Reprocessed Injection Grade ABS

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 230 / 3.8	5 g/10 min		ASTM D-1238
Density	1.04 g/cm ³	1.04 g/cm ³	ASTM D-792
Ash Content	%	%	ASTM D-5630
Linear Mold Shrinkage	in/in	mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched	4 ft-lb/in (kJ/m ²)	214 J/m	ASTM D-256
Tensile Strength @ Yield	5,500 psi (Mpa)	38 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	%	0 %	ASTM D-638
Flexural Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	300,000 psi (Mpa)	2,070 MPa	ASTM D-790
Rocwell Hardness	100 R Scale		ASTM D-785
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	165 Deg. F	74 Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

Flame Rating (3.0 mm)	UL94	HB @ 1.50mm
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The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions			
Process Variable	Description	Values	
Temperatures		F	C
Barrel	Rear	370 - 425	
	Center	400 - 450	
	Front	425 - 475	
	Nozzle	425 - 525	
	Mold	120 - 170	
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Drying			
Type		Dehumidifier	
Temperature		180° - 200° F (82° - 93°)	
Time		2 - 4 Hours	
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Special Requirements			
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Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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