



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

Technical Data Sheet
LCA® ABS 2-0011 Natural
General Purpose

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 230 / 3.8	12 g/10 min		ASTM D-1238
Melt Flow Rate @ 200 / 5.0	4.2 g/10 min		ASTM D-1238
Melt Flow Rate @ 220 / 10	35 g/10 min		ASTM D-1238
Melt Flow Rate @ 200 / 21.6	50 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	4.6 ft-lb/in (kJ/m ²)	246 J/m	ASTM D-256
Tensile Strength @ Yield	6,958 psi (Mpa)	48 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	15 %	15 %	ASTM D-638
Flexural Strength @ Yield	9,940 psi (Mpa)	69 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	340,800 psi (Mpa)	2,351 MPa	ASTM D-790
Rocwell Hardness	110 R Scale		ASTM D-785
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	185 Deg. F	85 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

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	390 - 450	198 - 232
	Center	400 - 450	204 - 232
	Front	425 - 500	218 - 260
	Nozzle	425 - 500	218 - 260
	Mold	80 - 150	27 - 66
	Melt	425 - 525	218 - 274
Drying			
Type		Dehumidifier	
Temperature		180° - 200° F (82° - 93°)	
Time		2 Hours	
Special Requirements			

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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