



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

## Technical Data Sheet

### LCA® ABS 20GF/R

#### Reprocessed ABS 20% Fiberglass Reinforced

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 260 / 5.0	5 g/10 min		ASTM D-1238
Density	1.2 g/cm <sup>3</sup>	1.2 g/cm <sup>3</sup>	ASTM D-792
Ash Content	20 %	20 %	ASTM D-5630
Linear Mold Shrinkage	0.001 - 0.002 in/in	mm/mm	ASTM D-955
<b>Mechanical Properties</b>			
Izod Impact - Notched	1 ft-lb/in (kJ/m <sup>2</sup> )	53 J/m	ASTM D-256
Tensile Strength @ Yield	7,500 psi (Mpa)	52 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	5 %	5 %	ASTM D-638
Flexural Strength @ Yield	12,300 psi (Mpa)	85 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	730,000 psi (Mpa)	5,037 MPa	ASTM D-790
<b>Thermal Properties</b>			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	210 Deg. F	99 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	
<b>Temperatures</b>		<b>F</b>	<b>C</b>
Barrel	Rear	370 - 425	
	Center	400 - 450	
	Front	425 - 475	
	Nozzle	425 - 525	
	Melt Temp	425 - 525	
	Mold	120 - 170	
<b>Drying</b>			
Type		Dehumidifier	
Temperature		180°F - 200°F	
Time		2 - 4 hours	
<b>Special Requirements</b>			

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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