



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

Technical Data Sheet

LCA® PC/ABS 20GF

Polycarbonate/ABS 20% Fiberglass Reinforced

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 260 / 5.0	9.3 g/10 min		ASTM D-1238
Density	1.276 g/cm ³	1.276 g/cm ³	ASTM D-792
Ash Content	20 %	20 %	ASTM D-5630
Linear Mold Shrinkage	0.004 in/in	0.004 mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched	1.1 ft-lb/in (kJ/m ²)	59 J/m	ASTM D-256
Tensile Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-638
Tensile Strength @ Break	11,086 psi (Mpa)	76 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	3.7 %	3.7 %	ASTM D-638
Flexural Strength @ Yield	16,547 psi (Mpa)	114 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	671,134 psi (Mpa)	4,631 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	-18 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	Deg. F	-18 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	480 - 530	
	Center	480 - 560	
	Front	500 - 570	
	Nozzle	500 - 570	
	Mold	130 - 190	
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Drying			
Type		Dehumidifier	
Temperature		225°F	
Time		3 - 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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