



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

Technical Data Sheet

LCA® PC/ABS 9000 Type

Polycarbonate/ABS Low Gloss, High Flow, High Impact, UV Stable

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 260 / 5.0	20 g/10 min		ASTM D-1238
Density	1.13 g/cm ³	1.13 g/cm ³	ASTM D-792
Ash Content	%	%	ASTM D-5630
Linear Mold Shrinkage	0.006 in/in	0.006 mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched	10 ft-lb/in (kJ/m ²)	535 J/m	ASTM D-256
Tensile Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-638
Tensile Strength @ Break	8,200 psi (Mpa)	57 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	75 %	75 %	ASTM D-638
Flexural Strength @ Yield	12,500 psi (Mpa)	86 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	335,000 psi (Mpa)	2,311 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	255 Deg. F	124 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	225 Deg. F	107 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 - 520
	Center	480 - 550
	Front	500 - 560
	Nozzle	500 - 560
	Mold	130 - 190
Drying		
Type		Dehumidifier
Temperature		225°F
Time		3 - 4 hours
Suggested Maximum Moisture		0.05%
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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