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

Technical Data Sheet

LCA® T-85

PC/ABS

Typical Compound Properties	Value / Measure				Test Methods
Physical Properties	**English Units (ISO)**		**Metric Units**		
Density	1.15	g/cm3	1.15	g/cm3	ASTM D-792
Ash Content		%	0	%	ASTM D-5630
Melt Flow	6	g/10 min			ASTM D-1238
Linear Mold Shrinkage		in/in	0	mm/mm	ASTM D-955
Mechanical Properties					
Izod Impact - Notched	9.00	ft-lb/in (kJ/m2)	481	J/m	ASTM D-256
Tensile Strength @ Yield	6,500	psi (Mpa)	45	MPa	ASTM D-638
Tensile Strength @ Break	7,000	psi (Mpa)	48	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		psi (Mpa)	-	MPa	ASTM D-790
Thermal Properties					
DTUL @ 66 psi (455 kPa)		Deg. F		Deg. C	ASTM D-648
@ 264 psi (1820 kPa)		Deg. F		Deg. C	ASTM D-648
Vicat Softening Temperature		Deg. F		Deg. C	ASTM D-1525
Melt Point		Deg. F		Deg. C	ASTM D-789-92e1

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

General Product Type Information

Uniplas, Inc. 1145 Sutton St. Howell, MI 48843

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

Technical Data Sheet

LCA® T-85

PC/ABS

Typical Processing Conditions

Process Variable	Description	Values	
Temperatures		**F**	**C**
Barrel	Rear	460 - 500	
	Center	480 - 520	
	Front	500 - 530	
	Nozzle	485 - 505	
	Mold	100 - 155	

Drying	
Type	Dehumidifier
Temperature	230°
Time	4 Hours
Max. % Moisture	

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.

Uniplas, Inc. 1145 Sutton St. Howell, MI 48843