



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

## Technical Data Sheet

### LCA® PPE/PS 1808

#### High Impact, Medium Flow, W/UV Stability Package

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 280 / 5.0	18 g/10 min		ASTM D-1238
Density	1.05 g/cm <sup>3</sup>	1.05 g/cm <sup>3</sup>	ASTM D-792
Linear Mold Shrinkage	0.006 in/in	0.006 mm/mm	ASTM D-955
<b>Mechanical Properties</b>			
Izod Impact - Notched	8 ft-lb/in (kJ/m <sup>2</sup> )	428 J/m	ASTM D-256
Gardner Impact (0.125)	180 in-lbs		ASTM D5420
Tensile Strength @ Yield	6,500 psi (Mpa)	45 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	60 %	60 %	ASTM D-638
Flexural Strength @ Yield	10,200 psi (Mpa)	70 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	305,000 psi (Mpa)	2,104 MPa	ASTM D-790
<b>Thermal Properties</b>			
0.125in, @ 264 psi (1820 kPa)	230 Deg. F	110 Deg. C	ASTM D-648
0.250in, @ 264 psi (1820 kPa)	245 Deg. F	118 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.

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



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

## Technical Data Sheet

### LCA® PPE/PS 1808

#### High Impact, Medium Flow, W/UV Stability Package

##### Typical Processing Conditions

Process Variable	Description	Values	
<b>Temperatures</b>		<b>F</b>	<b>C</b>
Barrel	Rear	430 - 520	
	Center	450 - 530	
	Front	470 - 540	
	Nozzle	490 - 540	
	Melt Temp	490 - 540	
	Mold Temperature	130 - 180	

##### Drying

Type	Dehumidifier
Temperature	225°F
Time	4 - 6 hours
Suggested Maximum Moisture	0.02%

##### 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**