



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

Technical Data Sheet

LCA® PPE+PS+PA 902 TYPE

General Purpose, Paintable, Medium Flow

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 280 / 2.16	3.5 g/10 min		ASTM D-1238
Melt Flow Rate @ 280 / 5.0	18 g/10 min		ASTM D-1238
Density	1.08 g/cm ³	1.08 g/cm ³	ASTM D-792
Linear Mold Shrinkage	0.011 in/in	0.011 mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched	3.2 ft-lb/in (kJ/m ²)	171 J/m	ASTM D-256
Gardner Impact (0.125)	180 in-lbs		ASTM D5420
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	55 %	55 %	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	31,000 psi (Mpa)	214 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	345 Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	275 Deg. F	135 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	490 - 560
	Center	500 - 560
	Front	510 - 560
	Nozzle	520 - 560
	Melt Temp	520 - 560
	Mold Temperature	520 - 560
		140 - 200
Drying		
Type		Dehumidifier
Temperature		225°F
Time		4 - 6 hours
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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