



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

Technical Data Sheet
LCA® T-85XF Type
Molding Grade High Flow PC/ABS

Typical Compound Properties	Value / Measure	Test Methods
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Physical Properties	English Units (ISO)	Metric Units	
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Density	1.15 g/cm ³	1.15 g/cm ³	ASTM D-792
Ash Content	%	0 %	ASTM D-5630
Melt Flow	20 g/10 min	g/10 min	ASTM D-1238
Linear Mold Shrinkage	in/in	0 mm/mm	ASTM D-955

Mechanical Properties			
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Izod Impact - Notched	11.00 ft-lb/in (kJ/m ²)	588 J/m	ASTM D-256
Tensile Strength @ Yield	9,000 psi (Mpa)	62 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	%	0 %	ASTM D-638
Flexural Strength @ Yield	14,000 psi (Mpa)	97 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	350,000 psi (Mpa)	2,415 MPa	ASTM D-790

Thermal Properties			
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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

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	460 - 500
	Center	480 - 520
	Front	500 - 530
	Nozzle	485 - 505
	Mold	100 - 155
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Drying		
Type		Dehumidifier
Temperature		230°
Time		4 Hours
Max. % Moisture		
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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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