



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

Technical Data Sheet
LCA® ABS 20GF Natural
20% Glass Filled

| Typical Compound Properties | Value / Measure | Test Methods |
|------------------------------|------------------------|--------------|
| Physical Properties | | |
| | English Units | |
| Melt Flow Rate @ 230 / 3.8 | 8 g/10 min | ASTM D-1238 |
| Density | 1.26 g/cm ³ | ASTM D-792 |
| Mechanical Properties | | |
| Izod Impact - Notched | 1.6 ft-lb/in | ASTM D-256 |
| Tensile Strength @ Yield | 11,900 psi | ASTM D-638 |
| Flexural Modulus | 950,000 psi | ASTM D-790 |
| Thermal Properties | | |

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 | 390 - 450 | 198 - 232 |
| | Center | 400 - 450 | 204 - 232 |
| | Front | 425 - 500 | 218 - 260 |
| | Nozzle | 425 - 500 | 218 - 260 |
| | Mold | 80 - 150 | 27 - 66 |
| | Melt | 425 - 525 | 218 - 274 |
| Drying | | | |
| Type | | Dehumidifier | |
| Temperature | | 180° - 200° F (82° - 93°) | |
| Time | | 2 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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