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Technical Data Sheet
LCA® PC/ABS ZF0509 Black
Unreinforced PC/ABS Alloy

Typical Compound Properties	Value / Measure	Test Methods
Physical Properties		
	English Units	
Density	1.13 g/cm ³	ASTM D-792
Melt Flow	5 g/10 min	ASTM D-1238
Mechanical Properties		
Izod Impact - Notched	9.00 ft-lb/in (kJ/m ²)	ASTM D-256
Tensile Strength	8,000 psi (Mpa)	ASTM D-638

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.

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



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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
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.