



## Technical Data Sheet

### LCA® ABS-ZF1506 Natural Injection molding ABS - High Impact

Typical Compound Properties	Value / Measure	Test Methods
<b>Physical Properties</b>	<b>English Units</b>	
Melt Flow Rate @ 230 / 3.8kg	3.7 g/10 min	ASTM D-1238
Melt Flow Rate @ 220 / 10kg	15 g/10 min	ASTM D-1238
Density	1.04 g/cm <sup>3</sup>	ASTM D-792
<b>Mechanical Properties</b>		
Izod Impact - Notched	6.5 ft-lb/in	ASTM D-256
Tensile Strength	6,000 psi	ASTM D-638
Flexural Modulus	310,000 psi	ASTM D-790
<b>Thermal Properties</b>		
HDT 264 psi	180 °F	ASTM D-648
HDT 66 psi	207 °F	ASTM D-648

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

Temperatures		F	C
Barrel	Rear	375 - 420	191 - 215
	Center	400 - 440	204 - 227
	Front	420 - 480	215 - 249
	Nozzle	425 - 500	218 - 260
	Mold	100 - 150	37 - 66
	Melt	425 - 515	218 - 268

#### Drying

Type	Dehumidifier
Temperature	180° - 200° F
Time	2 - 4 Hours
Suggested Max Moisture	0.10%

#### 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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