

DIAMALLOY ABSPC 9901

Polycarbonate + ABS
Network Polymers, Inc.

Message:

DIAMALLOY ABSPC 9901 is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in North America. Characteristics include:
Flame Rated
Impact Resistant

General Information			
Features	Ultra High Impact Resistance		
UL File Number	E119088		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹			ASTM D1238
200°C/5.0 kg	0.80	g/10 min	
230°C/3.8 kg	3.9	g/10 min	
Molding Shrinkage - Flow	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ² (Injection Molded)	2670	MPa	ASTM D638
Tensile Strength ³ (Yield)	55.2	MPa	ASTM D638
Flexural Modulus	2140	MPa	ASTM D790
Flexural Strength ⁴ (Break)	70.7	MPa	ASTM D790A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	590	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.18 mm	90.0	°C	
1.8 MPa, Annealed, 3.18 mm	100	°C	
Vicat Softening Temperature	125	°C	ASTM D1525 ⁵
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 70	%	
Suggested Max Regrind	30	%	

Rear Temperature	230 to 260	°C
Middle Temperature	235 to 265	°C
Front Temperature	238 to 272	°C
Nozzle Temperature	238 to 272	°C
Processing (Melt) Temp	238 to 272	°C
Mold Temperature	40.0 to 100	°C
Back Pressure	0.345 to 1.03	MPa

NOTE

1.	Procedure A
2.	Type I
3.	51 mm/min
4.	Method I (3 point load), Type I
5.	Loading 1 (10 N)

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