



Phone: (810) 326-1451 Fax: (586) 408-6363
 www.dynamicpolymer.com

Technical Data Sheet

DYN-PCABS Black

Polycarbonate + ABS, Unreinforced, Injection Molding Grade

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units	Metric Units	
Density	1.2 g/cm ³	1.2 g/cm ³	ASTM D-792
Melt Flow Rate @ 230° / 3.8kg	8 g/10 min		ASTM D-792
Mechanical Properties			
Izod Impact - Notched	12 ft-lb/in	642 J/m	ASTM D-256
Tensile Strength @ Yield	8,300 psi	57 MPa	ASTM D-638
Tensile Elongation @ Yield	5 %	5 %	ASTM D-638
Flexural Modulus	340,000 psi	2,346 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	260 Deg. F	128 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	226 Deg. F	109 Deg. C	ASTM D-648

All tests are performed on dry as molded ASTM test bars.

General Product Type Information

DYN-PCABS, is also available with internal and external lubricants, UV stabilized and other modifications. Manufactured with recycled content. Further information and details are available upon request.

Processing Information

Temperatures		F	C
Barrel	Rear	460 - 500	240 - 262
	Center	480 - 520	251 - 273
	Front	500 - 530	262 - 279
	Nozzle	480 - 500	251 - 262
	Mold	100 - 150	38 - 66

Drying

Type	Dehumidifier
Temperature	230°F
Time	3 - 4 hours
Max. % Moisture	0.05

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, Dynamic Polymer Solutions disclaims any liability for loss or damage incurred in connection with the use of this product. 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.