

Technical Data Sheet

**Diamaloy Abspc 9902 LM 1402 Black**

Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Laser Markable
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.12	1.12 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 kg)	20 g/10 min	20 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ² (Yield)	12500 psi	86.2 MPa	ASTM D638
Tensile Elongation (Break)	> 120 %	> 120 %	ASTM D638
Flexural Modulus	330000 psi	2280 MPa	ASTM D790
Flexural Strength ³ (Break)	12500 psi	86.2 MPa	ASTM D790A
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 in (3.18 mm)	12 ft·lb/in	640 J/m	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.125 in (3.18 mm)	265 °F	129 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	194 to 212 °F	90 to 100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	446 to 500 °F	230 to 260 °C
Middle Temperature	455 to 509 °F	235 to 265 °C
Front Temperature	460 to 522 °F	238 to 272 °C
Nozzle Temperature	460 to 522 °F	238 to 272 °C
Processing (Melt) Temp	460 to 522 °F	238 to 272 °C
Mold Temperature	104 to 212 °F	40 to 100 °C
Back Pressure	50.0 to 150 psi	0.345 to 1.03 MPa

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Notes

¹ Procedure A

² 2.0 in/min (51 mm/min)

³ Method I (3 point load), Type I

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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