

Technical Data Sheet



Diamaloy Asapc 938

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

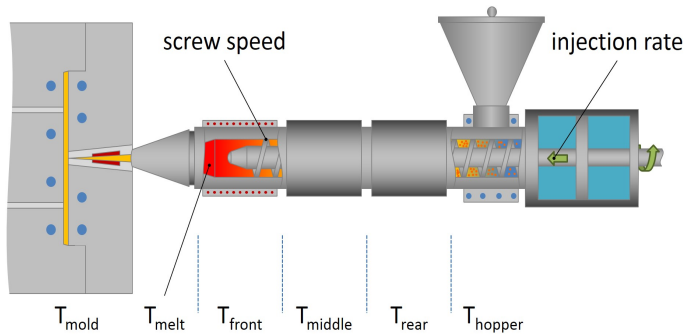
General			
Material Status	• Commercial: Active		
Availability	• North America		
Additive	• UV Stabilizer		
Forms	• Pellets		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.11	1.11 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (265°C/5.0 kg)	50 g/10 min	50 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus ²			ASTM D638
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	363000 psi	2500 MPa	
Tensile Strength ²			ASTM D638
Yield, 73°F (23°C), 0.125 in (3.18 mm), Injection Molded	7420 psi	51.2 MPa	
Tensile Elongation			ASTM D638
Break, 73°F (23°C), 0.125 in (3.18 mm), Injection Molded	40 %	40 %	
Flexural Modulus - Tangent ³			ASTM D790B
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	359000 psi	2480 MPa	
Flexural Strength ⁴			ASTM D790
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	11300 psi	78.2 MPa	
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256A
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	7.0 ft·lb/in	370 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), Injection Molded	178 °F	81.1 °C	
Vicat Softening Temperature	237 °F	114 °C	ASTM D1525

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 to 185 °F	80 to 85 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Suggested Shot Size	40 to 70 %	40 to 70 %
Rear Temperature	446 to 500 °F	230 to 260 °C
Middle Temperature	450 to 509 °F	232 to 265 °C
Front Temperature	455 to 522 °F	235 to 272 °C
Nozzle Temperature	428 to 522 °F	220 to 272 °C
Processing (Melt) Temp	428 to 522 °F	220 to 272 °C
Mold Temperature	104 to 176 °F	40 to 80 °C
Injection Rate	Fast	Fast
Back Pressure	75.0 to 150 psi	0.517 to 1.03 MPa

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Notes

- ¹ Procedure A
- ² Type I, 2.0 in/min (51 mm/min)
- ³ Method I (3 point load), 0.050 in/min (1.3 mm/min)
- ⁴ 0.050 in/min (1.3 mm/min)

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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