

Technical Data Sheet

**Diamaloy Asapc GLY 130 GF10**

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

General

Material Status	• Commercial: Active ¹
Availability	• North America
Additive	• UV Stabilizer
Forms	• Pellets

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.25	1.25 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ² (265°C/5.0 kg)	17 g/10 min	17 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Flexural Modulus ³	425000 psi	2930 MPa	ASTM D790B
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (0.125 in (3.18 mm))	2.3 ft·lb/in	120 J/m	ASTM D256A
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.250 in (6.35 mm)	235 °F	113 °C	ASTM D648

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 200 °F	82 to 93 °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 This is an experimental grade only.

² Procedure A

³ Method I (3 point load), 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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