



Phone: (517) 295-4196 Fax: (517) 295-4918

**Technical Data Sheet**  
**LCA® ABS 20GF Black**  
**20% Glass Filled**

Typical Compound Properties	Value / Measure	Test Methods
<b>Physical Properties</b>		
	English Units	
Melt Flow Rate @ 230 / 3.8	10 g/10 min	ASTM D-1238
Density	1.24 g/cm <sup>3</sup>	ASTM D-792
<b>Mechanical Properties</b>		
Izod Impact - Notched	1.1 ft-lb/in	ASTM D-256
Tensile Strength @ Yield	10,800 psi	ASTM D-638
Flexural Modulus	920,000 psi	ASTM D-790
<b>Thermal Properties</b>		

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

**General Product Type Information**

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, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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<b>Typical Processing Conditions</b>			
Process Variable	Description	Values	
<b>Temperatures</b>		<b>F</b>	<b>C</b>
Barrel	Rear	390 - 450	198 - 232
	Center	400 - 450	204 - 232
	Front	425 - 500	218 - 260
	Nozzle	425 - 500	218 - 260
	Mold	80 - 150	27 - 66
	Melt	425 - 525	218 - 274
<b>Drying</b>			
Type		Dehumidifier	
Temperature		180° - 200° F (82° - 93°)	
Time		2 Hours	
<b>Special Requirements</b>			

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.

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