



OmniCarb™
PC/ABS 1210
 General Purpose PC/ABS

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Melt Flow	g/10 min.	D1238	10	10
Specific Gravity		D792	1.15	1.15
Mold Shrinkage, Isotropic	in/in		.003 to .007	

IMPACT

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	12	641
--	-------------------	------	----	-----

MECHANICAL

Tensile Strength At Yield, 73°F	psi (MPa)	D638	8,600	59
Tensile Elongation	%	D638	>50	>50
Flexural Modulus	psi (MPa)	D790	340,000	2,344
Flexural Strength	psi (MPa)	D790	12,500	86

THERMAL

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	-	-
1/8" bar, 264 psi	°F (°C)	D648	230	110

FLAMMABILITY

Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
--	-------	------	-----	-----

RECOMMENDED PROCESSING CONDITIONS

Drying Temperature	220° F
Drying Time	3-4 hrs. max.
Maximum Moisture	0.02%
Rear Zone(s)	480 to 550° F
Middle Zone(s)	490 to 560° F
Front Zone(s)	500 to 570° F
Nozzle	480 to 560° F
Mold Temperature	100 to 200° F
Melt Temperature	500 to 575° F
Back Pressure	50 to 100 psi

Values are based on natural or black materials unless otherwise noted. Properties and values herein are based on laboratory test specimens and should not be used to establish minimum specification limits or fabricate tooling.

Omni does not guarantee the accuracy of this information or the suitability of this product in any given application or usage situation.