



OmniCarb™ PC/ASA 814 HSV

Weatherable, Impact Resistant, PC/ASA Compound

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Melt Flow	g/10 min	D1238	14	14
Specific Gravity		D792	1.14	1.14
Mold Shrinkage, Isotropic	in/in		.003 to .008	

IMPACT

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	8	427
--	-------------------	------	---	-----

MECHANICAL

Tensile Strength At Yield, 73°F	psi (MPa)	D638	7,800	54
Tensile Elongation	%	D638	3	3
Flexural Modulus	psi (MPa)	D790	320,000	2,206
Flexural Strength	psi (MPa)	D790	9,500	66

THERMAL

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	-	-
1/8" bar, 264 psi	°F (°C)	D648	205	96

FLAMMABILITY

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

RECOMMENDED PROCESSING CONDITIONS

Drying Temperature	190° F
Drying Time	4 hrs. max.
Maximum Moisture	0.04%
Rear Zone(s)	400 to 480° F
Middle Zone(s)	420 to 500° F
Front Zone(s)	420 to 500° F
Nozzle	420 to 500° F
Mold Temperature	80 to 140° F
Melt Temperature	420 to 500° 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.