

OP - PC - Filled 20GF

Polycarbonate

Oxford Polymers

Message:

OP - PC - Filled 20GF is a Polycarbonate (PC) material filled with 20% glass fiber. It is available in North America for injection molding.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.25	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5930	MPa	ASTM D638
Tensile Strength (Break)	110	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	5520	MPa	ASTM D790
Flexural Strength	131	MPa	ASTM D790
Compressive Strength	110	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	149	°C	
1.8 MPa, Unannealed	146	°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	282 to 293	°C	
Middle Temperature	282 to 293	°C	
Front Temperature	288 to 293	°C	
Nozzle Temperature	288 to 316	°C	
Processing (Melt) Temp	293	°C	
Mold Temperature	82.2 to 116	°C	
Injection Pressure	103	MPa	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

