

NAXELL™ PC110M

Polycarbonate

MRC Polymers, Inc.

Message:

PC110M is available in natural and custom colors, Further information and details are available upon request.

Polycarbonate for colorable products.

MFR can be modified between 10 to 40 g/10mins

Can be UV Stabilized

Internal and External lubricants can be added

Can be clear to color matched

Not for products that require stringent visual specification.

FR package cab be added

General Information			
Features	General		
Uses	General		
Appearance	Available colors		
	Clear/transparent		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 - 0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C, 3.18 mm)	62.1	MPa	ASTM D638
Tensile Elongation (Break, 23°C, 3.18 mm)	70	%	ASTM D638
Flexural Modulus (23°C, 3.18 mm)	2340	MPa	ASTM D790
Flexural Strength (23°C, 3.18 mm)	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	850	J/m	ASTM D256
Instrumented Dart Impact ¹ (23°C, 3.18 mm, Total Energy)	61.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	135	°C	ASTM D648
1.8 MPa, not annealed	129	°C	ASTM D648
CLTE - Flow (-40 to 35°C)	6.8E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	127 - 138	°C	

Drying Time	3.0 - 4.0	hr
Dew Point	< -17.8	°C
Suggested Max Moisture	0.020	%
Rear Temperature	254 - 271	°C
Middle Temperature	266 - 282	°C
Front Temperature	277 - 293	°C
Nozzle Temperature	277 - 293	°C
Processing (Melt) Temp	277 - 293	°C
Mold Temperature	48.9 - 93.3	°C
Injection Pressure	68.9 - 138	MPa
Injection Rate	Moderate	
Back Pressure	0.345 - 1.21	MPa
Screw Speed	50 - 75	rpm
Cushion	6.35	mm

Injection instructions

Packing: 50 to 75% of injection pressure Hold: 40 to 60% of injection pressure Air Flow Rate: 0.8-1.0 CFM per lb/hour resin processed

NOTE

1. 3.35 m/sec

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