

NEXUS PC/ABS PC/ABSQX7002

Polycarbonate + ABS
Nexus Resin Group, LLC.

Message:
Molding Grade PC/ABS High Flow

General Information			
Features	High Flow		
UL File Number	E205256		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2340	MPa	ASTM D638
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength (Yield)	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	590	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	113	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.57 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	232 to 260	°C	
Middle Temperature	246 to 274	°C	
Front Temperature	246 to 288	°C	
Nozzle Temperature	246 to 288	°C	
Processing (Melt) Temp	246 to 288	°C	
Mold Temperature	57.2 to 85.0	°C	
Back Pressure	0.172 to 0.689	MPa	
Screw Speed	25 to 75	rpm	

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