

CELEX™ 310HF.M

Polycarbonate Resin

Trinseo

Message:

CELEX™ 310HF.M glass fiber reinforced polycarbonate resin is a 10% glass fiber reinforced polycarbonate material. It provides a property balance of easy flow, superior ignition resistance, high rigidity, dimension stability and heat resistance. It provides the injection molded part with good aesthetics. It does not contain Chlorine/or Bromine and phosphate type flame retardants. It is designed for a wide range of applications, e.g. computer enclosures, electronic accessories and electrical appliances.

General Information			
UL YellowCard	E132010-100506962		
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Dimensional Stability		
	Good Flow		
	High Heat Resistance		
	High Rigidity		
	Pleasing Surface Appearance		
Uses	Appliances		
	Electrical/Electronic Applications		
	Housings		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 to 0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 3.20 mm, Injection Molded)	124		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 3.20 mm, Injection Molded)	70.0	MPa	ASTM D638
Tensile Elongation (Break, 3.20 mm, Injection Molded)	3.0	%	ASTM D638
Flexural Modulus (3.20 mm, Injection Molded)	4000	MPa	ASTM D790
Flexural Strength (3.20 mm, Injection Molded)	110	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	118	°C	
1.8 MPa, Unannealed	112	°C	
Vicat Softening Temperature	132	°C	ASTM D1525 ¹
Flammability	Nominal Value		Test Method
Flame Rating ²			UL 94
1.00 mm, WT and RD	V-1		
1.00 mm, BK and NC	V-0		
1.60 mm	V-0		
2.00 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Processing (Melt) Temp	271 to 310	°C	
Mold Temperature	60.0 to 100	°C	
NOTE			

1. Rate B (120°C/h), Loading 1 (10 N)

2. This rating not intended to reflect hazards presented by this or any other material under actual fire conditions.

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