

WONDERLOY® PC-540

Polycarbonate + ABS
CHI MEI CORPORATION

Message:

WONDERLOY® PC-540 is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.
Characteristics include:
Flame Rated
RoHS Compliant
Heat Resistant

General Information			
UL YellowCard	E56070-100269744	E194560-102142455	
Features	High Heat Resistance		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	22	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	23.5	cm³/10min	ISO 1133
Spiral Flow	11.2	cm	Internal Method
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.40	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 23°C	58.8	MPa	ASTM D638
Yield	64.0	MPa	ISO 527-2/50
Break	53.0	MPa	ISO 527-2/50
Tensile Elongation			
Break, 23°C	100	%	ASTM D638
Break	95	%	ISO 527-2/50
Flexural Modulus			
23°C	2460	MPa	ASTM D790
-- ¹	2500	MPa	ISO 178
Flexural Strength			
23°C	89.2	MPa	ASTM D790
-- ²	98.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
3.18 mm	640	J/m	ASTM D256
--	43	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed ³	92.0	°C	ASTM D648
1.8 MPa, Unannealed	85.0	°C	ISO 75-2/A
1.8 MPa, Annealed	96.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	107	°C	ASTM D1525 ⁴
--	106	°C	ISO 306/A50
--	99.0	°C	ISO 306/B50
CLTE - Flow (40 to 100°C)	6.0E-5 to 8.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
2.00 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	4.0	hr	
Rear Temperature	200 to 220	°C	
Middle Temperature	230 to 250	°C	
Front Temperature	220 to 240	°C	
Mold Temperature	40.0 to 70.0	°C	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	120°C/hr		
4.	Rate A (50°C/h), Loading 1 (10 N)		

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