

NEXUS PC/ABS PC/ABSQX7005

Polycarbonate + ABS
Nexus Resin Group, LLC.

Message:
Molding Grade PC/ABS

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2140	MPa	ASTM D638
Tensile Strength (Yield)	48.3	MPa	ASTM D638
Flexural Modulus	2140	MPa	ASTM D790
Flexural Strength (Yield)	68.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	530	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	107	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	87.8 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	238 to 274	°C	
Middle Temperature	260 to 274	°C	
Front Temperature	260 to 288	°C	
Nozzle Temperature	260 to 288	°C	
Processing (Melt) Temp	260 to 288	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.172 to 0.689	MPa	
Screw Speed	25 to 75	rpm	

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