

NAXALOY® 760

Polycarbonate + ABS

MRC Polymers, Inc.

Message:

Further information and details are available upon request.

High heat stability

Can be UV Stabilized

Internal and External lubricant can be added

General Information			
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.2	MPa	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength (Yield)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	430	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	104	°C	ASTM D648
Injection	Nominal Value	Unit	Test Method
Drying Temperature	110	°C	
Drying Time	4.0	hr	
Dew Point	< -17.8	°C	
Suggested Max Moisture	0.020	%	
Rear Temperature	249 - 271	°C	
Middle Temperature	260 - 277	°C	
Front Temperature	271 - 282	°C	
Nozzle Temperature	260 - 282	°C	
Processing (Melt) Temp	249 - 271	°C	
Mold Temperature	48.9 - 82.2	°C	
Injection Pressure	68.9 - 138	MPa	
Injection Rate	Moderate		

Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Cushion	3.30 - 6.35	mm

Injection instructions

Packing: 50 - 75% of injection pressureHold: 40 - 60% of injection pressureAirflow Rate: 0.8 - 1.0 CFM per lb/hour resin processed

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