

ASTALOY™ PC/PET C70L9

Polycarbonate + PET
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/PET C70L9 is an alloy of Polycarbonate (PC) and Polyethylene Terephthalate (PET) polymer which features extremely high impact strength, a high chemical resistance and an excellent balance of processability, heat resistance and rigidity.
Note: The letter "U" indicates UV stabilisation has been added [ie: ASTALOY™ PC/PET C70L9U].

General Information			
Features	Ultra-high impact resistance		
	Rigid, good		
	Workability, good		
	Good chemical resistance		
	Heat resistance, medium		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	59.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 180	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2250	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	86.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	900	J/m	ASTM D256
Dart Drop Impact (3.20 mm)	100	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 3.20mm	112	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	118	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	124	°C	ASTM D648
Vicat Softening Temperature	155	°C	ASTM D1525 ⁵
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (1.60 mm)	750	°C	AS/NZS 60695
Injection	Nominal Value	Unit	

Drying Temperature	120 - 140	°C
Drying Time	4.0 - 6.0	hr
Rear Temperature	250 - 260	°C
Middle Temperature	260 - 270	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	60.0 - 90.0	°C
Injection Pressure	60.0 - 140	MPa
Injection Rate	Slow-Moderate	
Back Pressure	0.300 - 1.00	MPa
Clamp Tonnage	4.0 - 8.0	kN/cm ²

Injection instructions

Screw Speed: Minimum

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | 压力1 (10N) |

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