

FRblend® PC-1304

Polycarbonate

Colour Image Plastic Compound Sdn. Bhd. (CIPC)

Message:

FRblend® PC-1304 is a medium viscosity flame retardant polycarbonate compound with good mold release and opaque colors.

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Mold Release		
	Medium Viscosity		
Uses	Electrical/Electronic Applications		
Appearance	Opaque		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	60.0	MPa	ASTM D638
Tensile Elongation (Break)	130	%	ASTM D638
Flexural Modulus	2250	MPa	ASTM D790
Flexural Strength	95.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 4.00 mm)	132	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.60 mm	V-2		
3.00 mm	V-0		
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	

Middle Temperature	240 to 250	°C
Front Temperature	250 to 260	°C
Nozzle Temperature	260 to 270	°C
Mold Temperature	80.0 to 120	°C

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Recommended distributors for this material

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