

OP - PC/PBT 604-I

Polycarbonate + PBT

Oxford Polymers

Message:

OP-PC/PBT 604-I is a polycarbonate polybutene terephthalate (PC PBT) material. This product is available in North America and is processed by injection molding.

The main features of OP-PC/PBT 604-I are:

flame retardant/rated flame

Impact resistance

chemical resistance

General Information			
Features	Impact resistance, high		
	Good chemical resistance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (285°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 - 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	50.3	MPa	ASTM D638
Fracture	51.7	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength	74.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (4°C)	850	J/m	ASTM D256
Dart Drop Impact (4°C)	0.904	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	98.9	°C	ASTM D648
1.8 MPa, not annealed	93.3	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.59 mm	HB		UL 94
3.18 mm	HB		UL 94
Additional Information			
Melt Mass -Flow Rate (MFR), ASTM D1238, 285°C/ 2.16kg: 5 to 15 g/10 min			
Injection	Nominal Value	Unit	

Drying Temperature	107 - 110	°C
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	249 - 271	°C
Middle Temperature	254 - 277	°C
Front Temperature	260 - 282	°C
Processing (Melt) Temp	246 - 274	°C
Mold Temperature	65.6 - 87.8	°C

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