

NEXUS PC PC1212FR

Polycarbonate
Nexus Resin Group, LLC.

Message:
Molding Grade PC FR

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
UL File Number	E205256		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2380	MPa	ASTM D638
Tensile Strength (Yield)	58.6	MPa	ASTM D638
Flexural Modulus	2380	MPa	ASTM D790
Flexural Strength (Yield)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	127	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	271 to 288	°C	
Middle Temperature	277 to 302	°C	
Front Temperature	288 to 316	°C	
Nozzle Temperature	288 to 316	°C	
Processing (Melt) Temp	288 to 316	°C	
Mold Temperature	76.7 to 104	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 75	rpm	

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