

OP - PC - Filled PC BK20 8SS

Polycarbonate

Oxford Polymers

Message:

EMI / ESD SHIELDING

General Information			
Filler / Reinforcement	Stainless steel fiber, 8.0% filler by weight		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	58.6	MPa	ASTM D638
Fracture	58.6	MPa	ASTM D638
Flexural Modulus	3450	MPa	ASTM D790
Flexural Strength	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (4°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	152	°C	ASTM D648
1.8 MPa, unannealed, 3.18mm	141	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2	ohms	ASTM D257
Flammability	Nominal Value	Unit	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, 230°C/ 3.8kg: 15 to 25 g/10 minSurface Resitivity, ASTM D257: 1E1 to 1E3 ohms			
Injection	Nominal Value	Unit	
Drying Temperature	107 - 121	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	282 - 293	°C	
Middle Temperature	282 - 293	°C	
Front Temperature	288 - 293	°C	

Processing (Melt) Temp	293 - 327	°C
Mold Temperature	82.2 - 104	°C

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