

DIAMALLOY ENGINEERED ALLOYS PC/PBT 627

Polycarbonate + PBT

Network Polymers, Inc.

Message:

DIAMALLOY ENGINEERED ALLOYS PC/PBT 627 is a Polycarbonate + PBT (PC+PBT) product. It is available in North America.

General Information			
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (260°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (Injection Molded)	1.3	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	46.9	MPa	ASTM D638
Tensile Elongation (Break)	< 100	%	ASTM D638
Flexural Modulus ³	2000	MPa	ASTM D790B
Flexural Strength ⁴ (Yield)	75.8	MPa	ASTM D790B
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	800	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	86.7	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	121	°C	
Drying Time - Desiccant Dryer	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.010	%	
Rear Temperature	243 to 266	°C	
Middle Temperature	254 to 277	°C	
Front Temperature	260 to 282	°C	
Nozzle Temperature	249 to 277	°C	
Melt Temperature (Aim)	271	°C	
Mold Temperature	54.4 to 82.2	°C	
Injection Pressure	55.2 to 96.5	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	0.345 to 0.517	MPa	
Back Pressure	0.552 to 1.03	MPa	
Screw Speed	50 to 75	rpm	
Clamp Tonnage	4.1 to 6.9	kN/cm ²	
Cushion	2.54 to 7.62	mm	

NOTE	
1.	Procedure A
2.	Type I, 51 mm/min
3.	Method I (3 point load), 1.3 mm/min
4.	Method I (3 point load), 1.3 mm/min

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