

NEXUS PC/PBT PC/PBT 7820

Polycarbonate + PBT
Nexus Resin Group, LLC.

Message:
Molding Grade PC/PBT

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.80 to 1.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1930	MPa	ASTM D638
Tensile Strength (Yield)	51.7	MPa	ASTM D638
Flexural Modulus	2030	MPa	ASTM D790
Flexural Strength (Yield)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	670	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	98.9	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	243 to 271	°C	
Middle Temperature	249 to 277	°C	
Front Temperature	257 to 282	°C	
Nozzle Temperature	257 to 274	°C	
Processing (Melt) Temp	260 to 279	°C	
Mold Temperature	65.6	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 75	rpm	

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