

LONoy Ionoy 1200

Polycarbonate + PBT
Kingfa

Message:

LONoy Ionoy 1200 is a polycarbonate polybutene terephthalate (PC PBT) material. This product is available in North America or Asia Pacific region. The processing method is injection molding.
The main features of LONoy Ionoy 1200 are:
beautiful
good weather resistance
Typical application areas include:
Automotive Industry
engineering/industrial accessories
business/office supplies

General Information			
Features	Good weather resistance		
	Excellent appearance		
Uses	Industrial components		
	Car anti-collision bar		
	Car interior equipment		
	Car exterior decoration		
	Business equipment		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	45	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.60 - 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.12	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	55.0	MPa	ASTM D638
Tensile Elongation ² (Break)	80	%	ASTM D638
Flexural Modulus ³	2200	MPa	ASTM D790
Flexural Strength ⁴	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	700	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.20 mm)	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, unannealed, 6.40mm	110	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	83.0	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength (1.60 mm)	28	kV/mm	ASTM D149
Additional Information			
Flammability, GM9070P, 1.6mm: <100 mm/min			
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	230 - 260	°C	
Middle Temperature	240 - 270	°C	
Front Temperature	240 - 270	°C	
Processing (Melt) Temp	240 - 270	°C	
Mold Temperature	70.0 - 90.0	°C	
Back Pressure	0.300 - 0.700	MPa	
Injection instructions			
Processing Temperature Limit: 280°C Injection Speed: 60 to 100%			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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