

NEXUS PC PC731

Polycarbonate
Nexus Resin Group, LLC.

Message:
Molding Grade PC

General Information			
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)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength (Yield)	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	129	°C	ASTM D648
Flammability	Nominal Value	Test Method	
	HB		
Flame Rating (1.57 mm)	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	288 to 316	°C	
Middle Temperature	302 to 329	°C	
Front Temperature	316 to 343	°C	
Nozzle Temperature	316 to 343	°C	
Processing (Melt) Temp	316 to 343	°C	
Mold Temperature	79.4 to 107	°C	
Back Pressure	0.345 to 1.38	MPa	
Screw Speed	40 to 100	rpm	

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