

AIE PC 1010F

Polycarbonate

Asia International Enterprise (Hong Kong) Limited

Message:

AIE PC 1010F is a polycarbonate (PC) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is injection molding. The main features of AIE PC 1010F are:
flame retardant/rated flame
Flame Retardant

General Information			
UL YellowCard	E252275-476078		
Features	Flame retardancy		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ISO 1133
Molding Shrinkage	0.50 - 0.80	%	Internal method
Water Absorption (23°C, 24 hr)	0.40	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	63.0	MPa	ISO 527-2
Tensile Strain (Break)	110	%	ISO 527-2
Flexural Modulus	2100	MPa	ISO 178
Flexural Stress	94.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	58	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	119	°C	ISO 75-2/B
1.8 MPa, not annealed	115	°C	ISO 75-2/A
Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm)	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	280 - 310	°C	
Middle Temperature	290 - 330	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	270 - 300	°C	

Mold Temperature	110 - 130	°C
Injection Pressure	40.0 - 100	MPa
Holding Pressure	40.0 - 50.0	MPa
Back Pressure	5.00 - 10.0	MPa
Screw Speed	40 - 70	rpm

Injection instructions

Cylinder Temperature 4: 270 to 290°C

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Recommended distributors for this material

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