

NAXELL™ PC110-10G

Polycarbonate

MRC Polymers, Inc.

Message:

PC110-10G is available in natural and custom colors. Further information and details are available upon request.

Glass content can be varied

Can be UV Stabilized

Internal and External lubricants can be added

Available in Natural and Black - can go colors

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Recycled Content	Yes		
Features	General		
	Medium viscosity		
Appearance	Black		
	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C, 3.18 mm)	76.0	MPa	ASTM D638
Tensile Elongation (Break, 23°C, 3.18 mm)	8.0	%	ASTM D638
Flexural Modulus (23°C, 3.18 mm)	3450	MPa	ASTM D790
Flexural Strength (23°C, 3.18 mm)	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Instrumented Dart Impact ¹ (23°C, 3.18 mm, Total Energy)	24.4	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	143	°C	ASTM D648
1.8 MPa, not annealed	138	°C	ASTM D648
CLTE - Flow (-40 to 35°C)	3.2E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	127	°C	

Drying Time	3.0 - 4.0	hr
Dew Point	< -17.8	°C
Suggested Max Moisture	0.020	%
Rear Temperature	293 - 327	°C
Middle Temperature	299 - 327	°C
Front Temperature	304 - 332	°C
Nozzle Temperature	293 - 332	°C
Processing (Melt) Temp	304 - 332	°C
Mold Temperature	65.6 - 116	°C
Injection Pressure	68.9 - 138	MPa
Injection Rate	Moderate	
Back Pressure	0.00 - 0.517	MPa
Screw Speed	30 - 75	rpm
Cushion	6.35	mm

Injection instructions

Packing: 50 to 75% of injection pressure Hold: 40 to 60% of injection pressure Air Flow Rate: 0.8-1.0 CFM per lb/hour resin processed

NOTE

1. 3.35 m/sec

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Recommended distributors for this material

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