

# NEXUS PC PC1212FRR

Polycarbonate  
Nexus Resin Group, LLC.

Message:  
Molding Grade PC FR

| General Information                                              |                   |                   |             |
|------------------------------------------------------------------|-------------------|-------------------|-------------|
| Additive                                                         | Flame Retardant   |                   |             |
|                                                                  | Mold Release      |                   |             |
| Features                                                         | Flame Retardant   |                   |             |
|                                                                  | Good Mold Release |                   |             |
| UL File Number                                                   | E205256           |                   |             |
| Processing Method                                                | Injection Molding |                   |             |
| Physical                                                         | Nominal Value     | Unit              | Test Method |
| Specific Gravity                                                 | 1.20              | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)                         | 12                | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow                                         | 0.50 to 0.70      | %                 | ASTM D955   |
| Mechanical                                                       | Nominal Value     | Unit              | Test Method |
| Tensile Modulus                                                  | 2380              | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                         | 58.6              | MPa               | ASTM D638   |
| Flexural Modulus                                                 | 2380              | MPa               | ASTM D790   |
| Flexural Strength (Yield)                                        | 86.2              | MPa               | ASTM D790   |
| Impact                                                           | Nominal Value     | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                              | 640               | J/m               | ASTM D256   |
| Thermal                                                          | Nominal Value     | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm) | 127               | °C                | ASTM D648   |
| Flammability                                                     | Nominal Value     |                   | Test Method |
| Flame Rating                                                     | HB                |                   | UL 94       |
| Injection                                                        | Nominal Value     | Unit              |             |
| Drying Temperature                                               | 121               | °C                |             |
| Drying Time                                                      | 4.0               | hr                |             |
| Suggested Max Moisture                                           | 0.020             | %                 |             |
| Rear Temperature                                                 | 271 to 288        | °C                |             |
| Middle Temperature                                               | 277 to 302        | °C                |             |
| Front Temperature                                                | 288 to 316        | °C                |             |
| Nozzle Temperature                                               | 288 to 316        | °C                |             |
| Processing (Melt) Temp                                           | 288 to 316        | °C                |             |

|                  |                |     |
|------------------|----------------|-----|
| Mold Temperature | 76.7 to 104    | °C  |
| Back Pressure    | 0.345 to 0.689 | MPa |
| Screw Speed      | 40 to 75       | rpm |

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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

