

Generic PC+Polyester

Polycarbonate + Polyester

Generic

Message:

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General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.19 - 1.20	g/cm³	ASTM D792
23°C	1.17 - 1.22	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	3.0 - 30	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (265°C/2.16 kg)	3.80 - 27.5	cm³/10min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.50 - 0.76	%	ASTM D955
Transverse flow: 23°C	0.50 - 0.66	%	ASTM D955
23°C	0.59 - 0.86	%	ISO 294-4
Water Absorption			ISO 62
Saturated, 23°C	0.12 - 0.51	%	ISO 62
Equilibrium, 23°C, 50% RH	0.050 - 0.70	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	1160 - 2480	MPa	ASTM D638
23°C	1470 - 2690	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	42.4 - 62.0	MPa	ASTM D638
Yield, 23°C	54.3 - 62.3	MPa	ISO 527-2
Fracture, 23°C	43.5 - 66.0	MPa	ASTM D638
Fracture, 23°C	44.4 - 62.2	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	4.9 - 6.1	%	ASTM D638
Yield, 23°C	5.0 - 6.0	%	ISO 527-2
Fracture, 23°C	97 - 150	%	ASTM D638
Fracture, 23°C	99 - 200	%	ISO 527-2
Flexural Modulus			
23°C	1160 - 2350	MPa	ASTM D790
23°C	1570 - 2330	MPa	ISO 178
Flexural Strength			

23°C	75.4 - 93.7	MPa	ASTM D790
23°C	58.0 - 92.2	MPa	ISO 178
Yield, 23°C	64.9 - 98.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0 - 73	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	70 - 1100	J/m	ASTM D256
23°C	7.0 - 11	kJ/m ²	ISO 180
Instrumented Dart Impact (23°C)	76.7 - 95.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	79.0 - 124	°C	ASTM D648
0.45 MPa, not annealed	123 - 138	°C	ISO 75-2/B
1.8 MPa, not annealed	72.0 - 114	°C	ASTM D648
1.8 MPa, not annealed	77.6 - 112	°C	ISO 75-2/A
Vicat Softening Temperature			
--	90.0 - 132	°C	ASTM D1525
--	91.0 - 133	°C	ISO 306
Linear thermal expansion coefficient			
Flow	7.0E-5 - 1.2E-4	cm/cm/°C	ASTM E831
Flow	5.9E-5 - 1.1E-4	cm/cm/°C	ISO 11359-2
Lateral	6.9E-5 - 1.1E-4	cm/cm/°C	ASTM E831
Lateral	6.7E-5 - 1.1E-4	cm/cm/°C	ISO 11359-2
Thermal Conductivity (23°C)	0.23	W/m/K	ISO 8302
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	2.0E+11 - 1.0E+15	ohms	ASTM D257
Volume Resistivity (23°C)	1.5E+11 - 2.4E+15	ohms · cm	ASTM D257
Optical	Nominal Value	Unit	Test Method
Transmittance	85.0 - 89.0	%	ASTM D1003
Haze	1.0 - 2.2	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 120	°C	
Drying Time	4.0 - 5.1	hr	
Drying Time, Maximum	8.0	hr	
Suggested Shot Size	60	%	
Rear Temperature	243 - 261	°C	
Middle Temperature	248 - 271	°C	
Front Temperature	254 - 281	°C	
Nozzle Temperature	240 - 281	°C	
Processing (Melt) Temp	254 - 269	°C	
Mold Temperature	51.0 - 77.0	°C	
Back Pressure	0.300 - 0.668	MPa	

Screw Speed	60 - 75	rpm
Vent Depth	0.017	mm
Injection instructions		

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