

WONDERLOY® PC-510

Polycarbonate + ABS
CHI MEI CORPORATION

Message:

WONDERLOY® PC-510 is a Polycarbonate + ABS (PC+ABS) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Typical application: Housings.
Characteristics include:
Flame Rated
RoHS Compliant
High Flow

General Information			
UL YellowCard	E56070-100239180		
Features	High Flow		
Uses	Housings		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.16	g/cm ³	ASTM D792
--	1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	22	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	23.5	cm ³ /10min	ISO 1133
Spiral Flow	15.7	cm	Internal Method
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.40	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 23°C	49.0	MPa	ASTM D638
Yield	57.0	MPa	ISO 527-2/50
Break	45.0	MPa	ISO 527-2/50
Tensile Elongation			
Break, 23°C	110	%	ASTM D638
Break	55	%	ISO 527-2/50
Flexural Modulus			
23°C	2450	MPa	ASTM D790
-- ¹	2600	MPa	ISO 178
Flexural Strength			

23°C	78.5	MPa	ASTM D790
-- ²	91.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
3.18 mm	710	J/m	ASTM D256
--	50	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed ³	78.0	°C	ASTM D648
1.8 MPa, Unannealed	76.0	°C	ISO 75-2/A
1.8 MPa, Annealed	87.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	94.0	°C	ASTM D1525 ⁴
--	95.0	°C	ISO 306/A50
--	88.0	°C	ISO 306/B50
CLTE - Flow (40 to 100°C)	6.0E-5 to 8.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.50 mm	V-0		
2.00 mm	5VB		
2.10 mm	5VB		
3.00 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	4.0	hr	
Rear Temperature	200 to 230	°C	
Middle Temperature	230 to 260	°C	
Front Temperature	220 to 250	°C	
Mold Temperature	40.0 to 60.0	°C	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	120°C/hr		
4.	Rate A (50°C/h), Loading 1 (10 N)		

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