

Clariant PC PC-010-L

Polycarbonate
Clariant Corporation

Message:

Clariant PC PC-010-L is a Polycarbonate (PC) material filled with 10% glass fiber. It is available in North America for injection molding.
Important attributes of Clariant PC PC-010-L are:
Good Stiffness
Lubricated

General Information			
UL YellowCard	E103015-218202		
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Lubricant		
Features	Good Stiffness		
	Lubricated		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	68.9	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	3100	MPa	ASTM D790
Flexural Strength	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	75	J/m	ASTM D256
Tensile Impact Strength	84.1	kJ/m²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	135	°C	
1.8 MPa, Unannealed	132	°C	
Melting Temperature	252	°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Regrind	20	%	
Rear Temperature	288 to 304	°C	
Middle Temperature	299 to 316	°C	
Front Temperature	304 to 338	°C	

Nozzle Temperature	304 to 338	°C
Processing (Melt) Temp	288 to 299	°C
Mold Temperature	82.2 to 116	°C
Injection Pressure	110 to 138	MPa
Back Pressure	0.345 to 1.38	MPa
Screw Speed	60 to 80	rpm

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Recommended distributors for this material

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