

# NEMCON H PC/ABS DP188

Polycarbonate + ABS

Ovation Polymers Inc.

Message:

Polycarbonate/Acrylonitrile Butadiene Styrene, thermally and electrically conducting grade.

| General Information                                        |                         |                   |                 |
|------------------------------------------------------------|-------------------------|-------------------|-----------------|
| Features                                                   | Electrically Conductive |                   |                 |
|                                                            | Thermally Conductive    |                   |                 |
| Processing Method                                          | Injection Molding       |                   |                 |
| Physical                                                   | Nominal Value           | Unit              | Test Method     |
| Specific Gravity                                           | 1.70                    | g/cm <sup>3</sup> | ASTM D792       |
| Molding Shrinkage                                          |                         |                   | ASTM D955       |
| Flow                                                       | 0.40                    | %                 |                 |
| Across Flow                                                | 0.20                    | %                 |                 |
| Mechanical                                                 | Nominal Value           | Unit              | Test Method     |
| Tensile Modulus <sup>1</sup> (23°C)                        | 49.0                    | MPa               | ASTM D638       |
| Tensile Strength <sup>2</sup> (Break, 23°C)                | 35.0                    | MPa               | ASTM D638       |
| Tensile Elongation <sup>3</sup> (Break, 23°C)              | 1.6                     | %                 | ASTM D638       |
| Flexural Modulus <sup>4</sup> (23°C, 50.0 mm Span)         | 3500                    | MPa               | ASTM D790       |
| Flexural Strength <sup>5</sup> (Break, 23°C, 50.0 mm Span) | 62.0                    | MPa               | ASTM D790       |
| Impact                                                     | Nominal Value           | Unit              | Test Method     |
| Notched Izod Impact (23°C)                                 | 32                      | J/m               | ASTM D256       |
| Thermal                                                    | Nominal Value           | Unit              | Test Method     |
| Thermal Conductivity                                       |                         |                   | Internal Method |
| -- <sup>6</sup>                                            | 0.80 to 1.1             | W/m/K             |                 |
| -- <sup>7</sup>                                            | 4.0 to 8.0              | W/m/K             |                 |
| Electrical                                                 | Nominal Value           | Unit              | Test Method     |
| Surface Resistivity                                        | 4.3E+9                  | ohms              | ASTM D257       |
| Injection                                                  | Nominal Value           | Unit              |                 |
| Drying Temperature                                         | 80.0 to 90.0            | °C                |                 |
| Drying Time                                                | 2.0 to 4.0              | hr                |                 |
| Suggested Max Moisture                                     | 0.050                   | %                 |                 |
| Rear Temperature                                           | 230 to 240              | °C                |                 |
| Middle Temperature                                         | 240 to 250              | °C                |                 |
| Front Temperature                                          | 250 to 260              | °C                |                 |
| Nozzle Temperature                                         | 260 to 270              | °C                |                 |
| Processing (Melt) Temp                                     | 255 to 265              | °C                |                 |

|                  |               |     |
|------------------|---------------|-----|
| Mold Temperature | 90.0 to 100   | °C  |
| Injection Rate   | Slow-Moderate |     |
| Back Pressure    | 0.138         | MPa |
| Screw Speed      | 60 to 80      | rpm |

| NOTE |               |  |
|------|---------------|--|
| 1.   | 50 mm/min     |  |
| 2.   | 50 mm/min     |  |
| 3.   | 50 mm/min     |  |
| 4.   | 1.3 mm/min    |  |
| 5.   | 1.3 mm/min    |  |
| 6.   | Through Plane |  |
| 7.   | In Plane      |  |

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