

SABIC® PC PC4800 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

PC4800 resin is a very high flow (MFR = 8.0 at 250C/1.2kg) polycarbonate product designed for use in the optical media market. It is available exclusively at www.sabicpc.com.

General Information			
Features	High liquidity		
Uses	Optical data storage		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/1.2 kg)	8.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (250°C/1.2 kg)	7.50	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Water Absorption			
Saturated, 23°C	0.35	%	ISO 62
Equilibrium, 23°C	0.35	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2350	MPa	ASTM D638
--	2350	MPa	ISO 527-2/1
Tensile Strength			
Yield ³	60.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Fracture ⁵	> 40	%	ASTM D638
Fracture	> 40	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2300	MPa	ASTM D790
-- ⁷	2300	MPa	ISO 178
Flexural Stress			
--	90.0	MPa	ISO 178
Yield, 50.0mm span ⁸	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁹			ISO 180/1A

-30°C	12	kJ/m ²	ISO 180/1A
23°C	15	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹⁰			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	132	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹¹	132	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	122	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹²	122	°C	ISO 75-2/Af
Vicat Softening Temperature	138	°C	ISO 306/B50, ASTM D1525 ¹³
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
CLTE - Flow			
-40 to 95°C	7.0E-5	cm/cm/°C	ASTM E831
23 to 80°C	7.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.20	W/m/K	ASTM C177, ISO 8302
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+15	ohms · cm	IEC 60093
Relative Permittivity (1 MHz)	3.00		IEC 60250
Dissipation Factor (1 MHz)	0.010		IEC 60250
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.586		ASTM D542, ISO 489
Transmittance (2540 µm)	> 90.0	%	ASTM D1003
Haze (2540 µm)	< 0.70	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	270 - 290	°C	
Middle Temperature	320 - 340	°C	
Front Temperature	350 - 380	°C	
Nozzle Temperature	340 - 370	°C	
Processing (Melt) Temp	340 - 370	°C	
Mold Temperature	75.0 - 95.0	°C	
NOTE			
1.	Tensile Bar		
2.	50 mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		

5.	Type 1, 50mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*3
10.	80*10*3
11.	80*10*4 mm
12.	80*10*4 mm
13.	标准 B (120°C/h), 载荷2 (50N)

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Recommended distributors for this material

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

