

NEXUS PC PC721HFR

Polycarbonate
Nexus Resin Group, LLC.

Message:
Molding Grade PC High Flow With Release

General Information			
Additive	Mold Release		
Features	Good Mold Release		
	High Flow		
UL File Number	E205256		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2380	MPa	ASTM D638
Tensile Strength (Yield)	60.0	MPa	ASTM D638
Flexural Modulus	2380	MPa	ASTM D790
Flexural Strength (Yield)	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	127	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.57 mm)	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	246 to 274	°C	
Middle Temperature	260 to 288	°C	
Front Temperature	274 to 302	°C	
Nozzle Temperature	274 to 302	°C	
Processing (Melt) Temp	274 to 302	°C	
Mold Temperature	71.1 to 98.9	°C	
Back Pressure	0.345 to 1.38	MPa	

Screw Speed

40 to 100

rpm

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