

MRC Polymers NAXALOY[®],ç 780 GF11 PC+PBT Polyester Blend, 11% Glass Fiber Filled

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate/Polybutylene Terephthalate (PBT) Blend, Glass Filled , Polyester, TP , Polybutylene Terephthalate (PBT)

Material Notes:

Good chemical resistance, impact and heat resistance Available in Black Only Can be UV Stabilized Internal and external lubricant can be added. Information provided by MRC Polymers Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_MRC-Polymers-NAXALOY-780-GF11-PCPBT-Polyester-Blend-11-Glass-Fiber-Filled.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.27 g/cc	1.27 g/cc	ASTM D792
Linear Mold Shrinkage	0.0040 - 0.0060 cm/cm	0.0040 - 0.0060 in/in	ASTM D955
Melt Flow	18 g/10 min @Load 5.00 kg, Temperature 250 Å°C	18 g/10 min @Load 11.0 lb, Temperature 482 Å°F	ISO 1133

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	77.98 MPa	11310 psi	ISO 527
Flexural Strength	116.97 MPa	16965 psi	ISO 178
Flexural Modulus	3.7490 GPa	543.75 ksi	ISO 178
Izod Impact, Notched (ISO)	8.00 kJ/mÅ²	3.81 ft-lb/inÅ²	ISO 180

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	108 Å°C	226 Å°F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	98.9 Å°C	210 Å°F	ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	240 - 270 Å°C	464 - 518 Å°F	
Middle Barrel Temperature	245 - 275 Å°C	473 - 527 Å°F	
Front Barrel Temperature	250 - 280 Å°C	482 - 536 Å°F	
Nozzle Temperature	245 - 275 Å°C	473 - 527 Å°F	
Melt Temperature	255 - 275 Å°C	491 - 527 Å°F	

Processing Properties	Metric	English	Comments
Drying Temperature	107 - 113 Â°C	225 - 235 Â°F	
Dry Time	3 - 4 hour	3 - 4 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Dew Point	<= -17.8 Â°C	<= 0.000 Â°F	
Drying Air Flow Rate	22.7 - 28.3 l/min	0.800 - 1.00 ftÂ³/min (CFM)	per lb/hour resin processed
Injection Pressure	34.5 - 172 MPa	5000 - 25000 psi	
Back Pressure	0.000 - 0.517 MPa	0.000 - 75.0 psi	
Shot Size	50 - 80 %	50 - 80 %	
Vent Depth	0.00127 - 0.00203 cm	0.000500 - 0.000800 in	
Cushion	0.635 cm	0.250 in	
Screw Speed	50 - 80 rpm	50 - 80 rpm	

Descriptive Properties	Value	Comments
Fill Rate	Moderate to Fast	
Hold Pressure	40-60% of injection pressure	
Packing Pressure	50-75% of injection pressure	

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