

MRC Polymers NAXALOY[®],ç 780 PC+PBT Polyester Blend

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

Material Notes:

Good chemical resistance, impact and heat resistance. Information provided by MRC Polymers Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_MRC-Polymers-NAXALOY-780-PCPBT-Polyester-Blend.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.20 g/cc	1.20 g/cc	solid; ASTM D792
Water Absorption	0.12 - 0.16 % @Temperature 22.8 Â°C, Time 86400 sec	0.12 - 0.16 % @Temperature 73.0 Â°F, Time 24.0 hour	ASTM D570
Linear Mold Shrinkage	0.0060 - 0.0090 cm/cm	0.0060 - 0.0090 in/in	ASTM D955

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	58.6 MPa	8500 psi	ASTM D638
Flexural Strength	86.2 MPa	12500 psi	ASTM D790
Flexural Modulus	2.34 GPa	340 ksi	ASTM D790
Izod Impact, Notched	6.94 J/cm	13.0 ft-lb/in	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	107 Â°C	225 Â°F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	100 Â°C	212 Â°F	ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	238 - 249 Â°C	460 - 480 Â°F	
Middle Barrel Temperature	243 - 254 Â°C	470 - 490 Â°F	
Front Barrel Temperature	254 - 266 Â°C	490 - 510 Â°F	
Nozzle Temperature	254 - 271 Â°C	490 - 520 Â°F	
Melt Temperature	249 - 271 Â°C	480 - 520 Â°F	
Mold Temperature	60.0 - 93.3 Â°C	140 - 200 Â°F	

Processing Properties	Metric	English	Comments
Dry Time	4 - 6 hour	4 - 6 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Dew Point	<= -17.8 °C	<= 0.000 °F	
Drying Air Flow Rate	22.7 - 28.3 l/min	0.800 - 1.00 ft ³ /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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