

MRC Polymers NAXALOY[®],ç 793A3 GF10 PC and Polyester Blend, 10% Glass Fiber Filled

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, 10% Glass Filled , Polyester, TP

Material Notes:

793 GF10 is available in natural and custom colors, internal and external lubricants, UV stabilizer and other modifications. Information provided by MRC Polymers Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_MRC-Polymers-NAXALOY-793A3-GF10-PC-and-Polyester-Blend-10-Glass-Fiber-Filled.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.29 g/cc	1.29 g/cc	ASTM D792
Linear Mold Shrinkage, Flow	0.0020 - 0.0050 cm/cm @Thickness 3.17 mm	0.0020 - 0.0050 in/in @Thickness 0.125 in	ASTM D955
Linear Mold Shrinkage, Transverse	0.0040 - 0.0070 cm/cm @Thickness 3.17 mm	0.0040 - 0.0070 in/in @Thickness 0.125 in	ASTM D955

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	68.9 MPa @Thickness 3.17 mm, Temperature 22.8 Â°C	10000 psi @Thickness 0.125 in, Temperature 73.0 Â°F	ASTM D638
Elongation at Break	5.0 % @Thickness 3.17 mm, Temperature 22.8 Â°C	5.0 % @Thickness 0.125 in, Temperature 73.0 Â°F	ASTM D638
Flexural Strength	103 MPa @Thickness 3.17 mm, Temperature 22.8 Â°C	15000 psi @Thickness 0.125 in, Temperature 73.0 Â°F	ASTM D790
Flexural Modulus	3.10 GPa @Thickness 3.17 mm, Temperature 22.8 Â°C	450 ksi @Thickness 0.125 in, Temperature 73.0 Â°F	ASTM D790
Izod Impact, Notched	1.33 J/cm @Thickness 3.17 mm, Temperature 22.8 Â°C	2.50 ft-lb/in @Thickness 0.125 in, Temperature 73.0 Â°F	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	132 Â°C @Thickness 3.17 mm	270 Â°F @Thickness 0.125 in	un-annealed; ASTM D648

Thermal Properties	Metric	English	Comments
Stress at Break at 1.8 MPa (26.4 psi)	110 Å°C	230 Å°F	MP - unspecified; ASTM D648
	@Thickness 3.17 mm	@Thickness 0.125 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	243 - 254 Å°C	470 - 490 Å°F	
Middle Barrel Temperature	249 - 260 Å°C	480 - 500 Å°F	
Front Barrel Temperature	254 - 266 Å°C	490 - 510 Å°F	
Nozzle Temperature	257 - 268 Å°C	495 - 515 Å°F	
Melt Temperature	260 - 277 Å°C	500 - 530 Å°F	
Mold Temperature	37.8 - 93.3 Å°C	100 - 200 Å°F	
Drying Temperature	104 - 121 Å°C	220 - 250 Å°F	
Dry Time	6 - 8 hour	6 - 8 hour	
Moisture Content	<= 0.010 %	<= 0.010 %	
Dew Point	<= -17.8 Å°C	<= 0.000 Å°F	
Drying Air Flow Rate	22.7 - 28.3 l/min	0.800 - 1.00 ftÅ³/min (CFM)	per lb/hour resin processed
Injection Pressure	68.9 - 138 MPa	10000 - 20000 psi	
Back Pressure	0.000 - 0.517 MPa	0.000 - 75.0 psi	
Cushion	0.635 cm	0.250 in	
Screw Speed	20 - 50 rpm	20 - 50 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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