

## MRC Polymers NAXELL<sup>®</sup>,ç PC110-919 General Purpose Polycarbonate, Medium High MFR

Category : Polymer , Thermoplastic , Polycarbonate (PC)

### Material Notes:

Polycarbonate for colorable productsMFR can be modified between 10 to 40 g/10minCan be UV stabilizedInternal and external lubricant can be addedCan be clear to color matchedNot for products that require stringent visual specificationFR package can be addedInformation provided by MRC Polymers Inc.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_MRC-Polymers-NAXELL-PC110-919-General-Purpose-Polycarbonate-Medium-High-MFR.php](http://www.lookpolymers.com/polymer_MRC-Polymers-NAXELL-PC110-919-General-Purpose-Polycarbonate-Medium-High-MFR.php)

Physical Properties	Metric	English	Comments
Specific Gravity	1.20 g/cc	1.20 g/cc	solid; ASTM D792
Water Absorption	0.15 % @Temperature 22.8 Å°C, Time 86400 sec	0.15 % @Temperature 73.0 Å°F, Time 24.0 hour	ASTM D570
Linear Mold Shrinkage, Flow	0.0050 - 0.0070 cm/cm @Thickness 3.17 mm	0.0050 - 0.0070 in/in @Thickness 0.125 in	ASTM D955
Melt Flow	15 g/10 min @Load 1.20 kg, Temperature 300 Å°C	15 g/10 min @Load 2.65 lb, Temperature 572 Å°F	nominal; ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	62.1 MPa @Thickness 3.17 mm, Temperature 22.8 Å°C	9000 psi @Thickness 0.125 in, Temperature 73.0 Å°F	ASTM D638
Elongation at Break	60 % @Thickness 3.17 mm, Temperature 22.8 Å°C	60 % @Thickness 0.125 in, Temperature 73.0 Å°F	ASTM D638
Flexural Strength	96.5 MPa @Thickness 3.17 mm, Temperature 22.8 Å°C	14000 psi @Thickness 0.125 in, Temperature 73.0 Å°F	ASTM D790
Flexural Modulus	2.34 GPa @Thickness 3.17 mm, Temperature 22.8 Å°C	340 ksi @Thickness 0.125 in, Temperature 73.0 Å°F	ASTM D790
Izod Impact, Notched	8.54 J/cm @Thickness 3.17 mm, Temperature 22.8 Å°C	16.0 ft-lb/in @Thickness 0.125 in, Temperature 73.0 Å°F	ASTM D256

Mechanical Properties	Metric	English	Comments
Dart Drop, Total Energy	@Thickness 3.17 mm, Temperature 22.8 Å°C	@Thickness 0.125 in, Temperature 73.0 Å°F	7.5MPH; ASTM D3763

Thermal Properties	Metric	English	Comments
CTE, linear	68.0 Åµm/m-Å°C @Temperature -40.0 - 35.0 Å°C	37.8 Åµin/in-Å°F @Temperature -40.0 - 95.0 Å°F	ASTM D696
Deflection Temperature at 0.46 MPa (66 psi)	135 Å°C @Thickness 3.17 mm	275 Å°F @Thickness 0.125 in	un-annealed; ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	125 Å°C @Thickness 3.17 mm	257 Å°F @Thickness 0.125 in	un-annealed; ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	254 - 271 Å°C	490 - 520 Å°F	
Middle Barrel Temperature	266 - 282 Å°C	510 - 540 Å°F	
Front Barrel Temperature	277 - 293 Å°C	530 - 560 Å°F	
Nozzle Temperature	277 - 293 Å°C	530 - 560 Å°F	
Melt Temperature	271 - 293 Å°C	520 - 560 Å°F	
Mold Temperature	48.9 - 93.3 Å°C	120 - 200 Å°F	
Drying Temperature	116 Å°C	240 Å°F	
Dry Time	3 - 4 hour	3 - 4 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
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	0.345 - 1.21 MPa	50.0 - 175 psi	
Cushion	0.635 cm	0.250 in	
Screw Speed	50 - 75 rpm	50 - 75 rpm	

Descriptive Properties	Value	Comments
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Descriptive Properties	Value <small>ate</small>	Comments
Hold Pressure	40-60% of injection pressure	
Packing Pressure	50-75% of injection pressure	

## Contact Songhan Plastic Technology Co.,Ltd.

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