

MRC Polymers NAXELL[®],_ç PC210MR General Purpose Polycarbonate, Medium MFR, with Release

Category : Polymer , Thermoplastic , Polycarbonate (PC)

Material Notes:

Medium melt without impact modification MFR can be modified between 10 to 40 g/10min Can be UV stabilized Internal and external lubricant can be added Generally for black and gray colors only FR package can be added Information provided by MRC Polymers Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_MRC-Polymers-NAXELL-PC210MR-General-Purpose-Polycarbonate-Medium-MFR-with-Release.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.20 g/cc	1.20 g/cc	ASTM D792
Linear Mold Shrinkage, Flow	0.0050 - 0.0080 cm/cm @Thickness 3.17 mm	0.0050 - 0.0080 in/in @Thickness 0.125 in	ASTM D955
Melt Flow	12 g/10 min @Load 1.20 kg, Temperature 300 Å°C	12 g/10 min @Load 2.65 lb, Temperature 572 Å°F	nominal; ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	57.9 MPa @Thickness 3.17 mm, Temperature 22.8 Å°C	8400 psi @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	6.41 J/cm @Thickness 3.17 mm, Temperature 22.8 Å°C	12.0 ft-lb/in @Thickness 0.125 in, Temperature 73.0 Å°F	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	132 Å°C @Thickness 3.17 mm	270 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

Thermal Properties	Metric	English	Comments
Processing Properties	Metric	English	Comments
Rear Barrel Temperature	260 - 271 Å°C	500 - 520 Å°F	
Middle Barrel Temperature	266 - 277 Å°C	510 - 530 Å°F	
Front Barrel Temperature	271 - 282 Å°C	520 - 540 Å°F	
Nozzle Temperature	271 - 282 Å°C	520 - 540 Å°F	
Melt Temperature	271 - 293 Å°C	520 - 560 Å°F	
Mold Temperature	48.9 - 76.7 Å°C	120 - 170 Å°F	
Drying Temperature	116 Å°C	240 Å°F	
Dry Time	4 hour	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	
Vent Depth	0.00762 cm	0.00300 in	
Cushion	0.635 cm	0.250 in	
Screw Speed	50 - 75 rpm	50 - 75 rpm	

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

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