

MRC Polymers NAXELL[®],ç PC23M-10G General Purpose Polycarbonate, 10% Glass Fiber Filled, Low Viscosity

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

Material Notes:

Can be impact modified Internal and external lubricant can be added Black only Information provided by MRC Polymers Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_MRC-Polymers-NAXELL-PC23M-10G-General-Purpose-Polycarbonate-10-Glass-Fiber-Filled-Low-Viscosity.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.25 g/cc	1.25 g/cc	solid; ASTM D792
Linear Mold Shrinkage, Flow	0.0020 - 0.0040 cm/cm @Thickness 3.17 mm	0.0020 - 0.0040 in/in @Thickness 0.125 in	ASTM D955
Melt Flow	36 g/10 min @Load 1.20 kg, Temperature 300 Å°C	36 g/10 min @Load 2.65 lb, Temperature 572 Å°F	nominal; ASTM D1238

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

Thermal Properties	Metric	English	Comments
CTE, linear	36.0 Åµm/m-Å°C @Temperature -40.0 - 35.0 Å°C	20.0 Åµin/in-Å°F @Temperature -40.0 - 95.0 Å°F	ASTM D696

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	141.4 °C @Thickness 3.17 mm	286.5 °F @Thickness 0.125 in	un-annealed; ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	135 °C @Thickness 3.17 mm	275 °F @Thickness 0.125 in	un-annealed; ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	249 - 271 °C	480 - 520 °F	
Middle Barrel Temperature	260 - 282 °C	500 - 540 °F	
Front Barrel Temperature	271 - 293 °C	520 - 560 °F	
Nozzle Temperature	271 - 293 °C	520 - 560 °F	
Melt Temperature	271 - 282 °C	520 - 540 °F	
Mold Temperature	65.6 - 93.3 °C	150 - 200 °F	
Drying Temperature	116 - 121 °C	240 - 250 °F	
Dry Time	3 - 4 hour	3 - 4 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	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	
Hold Pressure	40-60% of injection pressure	
Packing Pressure	50-75% of injection pressure	

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