

MRC Polymers NAXELL, PC429HHI Polycarbonate, Impact Modified, High MFR, EZ Flow

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Impact Modified

Material Notes:

Good Property Retention Heat and Dimensional Stability High Melt Impact Modified MFR can be modified between 10 to 26 g/10mins Can be UV stabilized Generally for natural, colorable and can go black Internal and external lubricant can be added 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-PC429HHI-Polycarbonate-Impact-Modified-High-MFR-EZ-Flow.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.19 g/cc	1.19 g/cc	ASTM D792
Linear Mold Shrinkage	0.0050 - 0.0080 cm/cm	0.0050 - 0.0080 in/in	ASTM D955
Melt Flow	23 g/10 min @Load 1.20 kg, Temperature 300 °C	23 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	55.2 MPa	8000 psi	ASTM D638
Flexural Strength	86.2 MPa	12500 psi	ASTM D790
Flexural Modulus	2.07 GPa	300 ksi	ASTM D790
Izod Impact, Notched	6.41 J/cm	12.0 ft-lb/in	ASTM D256
Falling Dart Impact	55.6 J @Temperature 22.8 °C	41.0 ft-lb @Temperature 73.0 °F	ASTM D3763
	59.7 J @Temperature -28.9 °C	44.0 ft-lb @Temperature -20.0 °F	ASTM D3763

Thermal Properties	Metric	English	Comments
CTE, linear	65.0 µm/m-°C @Temperature -40.0 - 35.0 °C	36.1 µin/in-°F @Temperature -40.0 - 95.0 °F	ASTM D696
Deflection Temperature at 0.46 MPa (66 psi)	124 °C @Thickness 3.17 mm	255 °F @Thickness 0.125 in	un-annealed; ASTM D648

Thermal Properties	Metric	English	Comments
Temperature at 1.8 MPa (264 psi)	114 Å°C	237 Å°F	(if indicated), ASTM D648
	@Thickness 3.17 mm	@Thickness 0.125 in	

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	260 - 282 Å°C	500 - 540 Å°F	
Middle Barrel Temperature	271 - 293 Å°C	520 - 560 Å°F	
Front Barrel Temperature	282 - 293 Å°C	540 - 560 Å°F	
Nozzle Temperature	282 - 293 Å°C	540 - 560 Å°F	
Melt Temperature	260 - 282 Å°C	500 - 540 Å°F	
Mold Temperature	48.9 - 82.2 Å°C	120 - 180 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 - 1.03 MPa	50.0 - 150 psi	
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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