

Ravago Manufacturing Americas Hylex® P1025G10 HB Polycarbonate, 10% Glass Reinforced

Category : Polymer , Thermoplastic , Polycarbonate (PC)

Material Notes:

Information provided by Ravago.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylex-P1025G10-HB-Polycarbonate-10-Glass-Reinforced.php

| Physical Properties | Metric | English | Comments |
|-----------------------------|--|--|----------------------------|
| Specific Gravity | 1.25 g/cc | 1.25 g/cc | ASTM D792 |
| Water Absorption | 0.14 % | 0.14 % | 24-Hr Immersion; ASTM D570 |
| Linear Mold Shrinkage, Flow | 0.0020 - 0.0050 cm/cm | 0.0020 - 0.0050 in/in | ASTM D955 |
| Melt Flow | 22 - 28 g/10 min @Load 3.80 kg, Temperature 230 °C | 22 - 28 g/10 min @Load 8.38 lb, Temperature 446 °F | ASTM D1238 |

| Mechanical Properties | Metric | English | Comments |
|-------------------------|---------------------------------|--------------------------------------|-----------|
| Tensile Strength, Yield | 79.3 MPa | 11500 psi | ASTM D638 |
| Elongation at Break | 2.2 % | 2.2 % | ASTM D638 |
| Flexural Strength | 114 MPa | 16500 psi | ASTM D790 |
| Flexural Modulus | 4.14 GPa | 600 ksi | ASTM D790 |
| Izod Impact, Notched | 1.07 J/cm @Thickness 3.17 mm | 2.00 ft-lb/in @Thickness 0.125 in | ASTM D256 |

| Thermal Properties | Metric | English | Comments |
|---|--------|---------|------------|
| Deflection Temperature at 0.46 MPa (66 psi) | 132 °C | 270 °F | ASTM D648 |
| Deflection Temperature at 1.8 MPa (264 psi) | 128 °C | 262 °F | ASTM D648 |
| Vicat Softening Point | 149 °C | 300 °F | ASTM D1525 |

| Electrical Properties | Metric | English | Comments |
|------------------------|-----------------|-----------------|-------------------|
| Electrical Resistivity | 4.00e+16 ohm-cm | 4.00e+16 ohm-cm | ASTM D257 |
| Dielectric Strength | 16.1 kV/mm | 410 kV/in | in Air; ASTM D149 |

| Electrical Properties | @Thickness 3.17 mm Metric | @Thickness 0.125 in English | Comments |
|-----------------------|------------------------------|--------------------------------|-----------|
| Arc Resistance | 120 sec | 120 sec | ASTM D495 |

| Processing Properties | Metric | English | Comments |
|---------------------------|-------------------|----------------|--------------|
| Rear Barrel Temperature | 254 - 271 °C | 490 - 520 °F | |
| Middle Barrel Temperature | 266 - 277 °C | 510 - 530 °F | |
| Front Barrel Temperature | 271 - 282 °C | 520 - 540 °F | |
| Nozzle Temperature | 271 - 288 °C | 520 - 550 °F | |
| Melt Temperature | 271 - 293 °C | 520 - 560 °F | |
| Mold Temperature | 71.1 - 93.3 °C | 160 - 200 °F | |
| Drying Temperature | 121 °C | 250 °F | |
| Dry Time | 3 - 4 hour | 3 - 4 hour | |
| | 6 - 8 hour | 6 - 8 hour | with regrind |
| Injection Pressure | 5.52 - 11.0 MPa | 800 - 1600 psi | |
| Hold Pressure | 5.52 - 8.27 MPa | 800 - 1200 psi | |
| Back Pressure | 0.345 - 0.689 MPa | 50.0 - 100 psi | |
| Shot Size | 40 - 60 % | 40 - 60 % | To Cylinder |
| Screw Speed | 40 - 70 rpm | 40 - 70 rpm | |

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