

NEXUS PC PCGF20

Polycarbonate
Nexus Resin Group, LLC.

Message:
Molding Grade PC With 20% Glass

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5140	MPa	ASTM D638
Tensile Strength (Yield)	96.5	MPa	ASTM D638
Flexural Modulus	5170	MPa	ASTM D790
Flexural Strength (Yield)	121	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	141	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	288 to 316	°C	
Middle Temperature	302 to 329	°C	
Front Temperature	316 to 343	°C	
Nozzle Temperature	316 to 343	°C	
Processing (Melt) Temp	316 to 343	°C	
Mold Temperature	79.4 to 107	°C	
Back Pressure	0.345 to 1.38	MPa	
Screw Speed	40 to 100	rpm	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

