

NAXELL™ PC100H

Polycarbonate

MRC Polymers, Inc.

Message:

PC100H is available in natural and opaque colors, Information and details are available upon request.

High Quality, High Melt Polycarbonate

MFR can be modified between 10 to 40 g/10mins

Can be UV Stabilized

Internal and External lubricants can be added

Can be clear to color matched

General Information			
Features	High liquidity		
	General		
Uses	General		
Appearance	Unspecified Color		
	Opacity		
	Clear/transparent		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	23	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 - 0.70	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C, 3.18 mm)	62.1	MPa	ASTM D638
Tensile Elongation (Break, 23°C, 3.18 mm)	80	%	ASTM D638
Flexural Modulus (23°C, 3.18 mm)	2280	MPa	ASTM D790
Flexural Strength (Yield, 23°C, 3.18 mm)	93.1	MPa	ASTM D790
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	132	°C	ASTM D648
1.8 MPa, unannealed, 3.18mm	127	°C	ASTM D648
CLTE - Flow (-40 to 35°C)	6.8E-5	cm/cm/°C	ASTM D696
Optical	Nominal Value	Unit	Test Method
Transmittance	78.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	116	°C	

Drying Time	3.0 - 4.0	hr
Dew Point	< -17.8	°C
Suggested Max Moisture	0.020	%
Rear Temperature	249 - 260	°C
Middle Temperature	260 - 271	°C
Front Temperature	271 - 282	°C
Nozzle Temperature	271 - 282	°C
Processing (Melt) Temp	249 - 282	°C
Mold Temperature	48.9 - 93.3	°C
Injection Pressure	68.9 - 138	MPa
Injection Rate	Moderate	
Back Pressure	0.345 - 1.21	MPa
Screw Speed	50 - 75	rpm
Cushion	6.35	mm

Injection instructions

Packing: 50 to 75% of injection pressure Hold: 40 to 60% of injection pressure Air Flow Rate: 0.8-1.0 CFM per lb/hour resin processed

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