

ASTALON™ N5+

Polycarbonate
Marplex Australia Pty. Ltd.

Message:

ASTALON™ N5+ is a clear, flame retardant polycarbonate grade with standard medium viscosity (medium melt flow) in the ASTALON™ range. It is designed to meet the stringent UL94 V-0 rating while still keeping very high clarity and many other features of polycarbonate. N5+ is suited to injection moulding applications which require a mould release agent. N5+ offers an exceptional combination of flame retardancy, transparency, toughness, heat resistance and processability, typical applications include computer and electrical appliances.
Note: [Suffix "+" = R for mould release or "+" =UR for UV stabilised for improved weatherability]

General Information			
Additive	Mold Release		
Features	Flame Retardant		
	High Clarity		
	Medium Flow		
	Medium Viscosity		
Uses	Appliances		
	Computer Components		
	Electrical/Electronic Applications		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	70.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	120	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2550	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	65	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	125	°C	ASTM D648
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+16	ohms · cm	ASTM D257

Dielectric Constant ⁵	27.0	pF/m	ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating (2.00 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 to 125	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	245 to 265	°C	
Middle Temperature	260 to 280	°C	
Front Temperature	275 to 295	°C	
Processing (Melt) Temp	270 to 300	°C	
Mold Temperature	60.0 to 110	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	4.0 to 8.0	kN/cm ²	
NOTE			
1.	20 mm/min		
2.	20 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		
5.	1 MHz		

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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

