

NAXALOY® 770PG

Polycarbonate + ABS
MRC Polymers, Inc.

Message:
Integrally Colored Resin. Further information and details are available upon request.

General Information			
Features	Electroplateable		
	Good coloring		
Appearance	Unspecified Color		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	51.7	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	530	J/m	ASTM D256
Instrumented Dart Impact (-29°C)	50.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	110	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	4.0	hr	
Dew Point	< -17.8	°C	
Suggested Max Moisture	0.020	%	
Rear Temperature	260 - 271	°C	
Middle Temperature	266 - 277	°C	
Front Temperature	271 - 282	°C	
Nozzle Temperature	260 - 282	°C	
Processing (Melt) Temp	271 - 293	°C	
Mold Temperature	60.0 - 82.2	°C	

Injection Pressure	68.9 - 138	MPa
Injection Rate	Slow-Moderate	
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Cushion	3.30 - 6.35	mm

Injection instructions

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

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Recommended distributors for this material

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