

AIE PC 10G4

Polycarbonate

Asia International Enterprise (Hong Kong) Limited

Message:

AIE PC 10G4 is a polycarbonate (PC) material, which contains a 20% glass fiber reinforced material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is injection molding.

The main features of AIE PC 10G4 are:

- flame retardant/rated flame
- Hard
- Good dimensional stability

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Molding Shrinkage	0.20 - 0.40	%	Internal method
Water Absorption (23°C, 24 hr)	0.40	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	115	MPa	ISO 527-2
Tensile Strain (Break)	5.0	%	ISO 527-2
Flexural Modulus	6300	MPa	ISO 178
Flexural Stress	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	19	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	150	°C	ISO 75-2/B
1.8 MPa, not annealed	145	°C	ISO 75-2/A
Flammability	Nominal Value	Test Method	
Flame Rating	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	280 - 310	°C	
Middle Temperature	290 - 330	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	270 - 300	°C	

Mold Temperature	80.0 - 120	°C
Injection Pressure	40.0 - 100	MPa
Holding Pressure	40.0 - 50.0	MPa
Back Pressure	5.00 - 10.0	MPa
Screw Speed	40 - 70	rpm

Injection instructions

Cylinder Temperature 4: 270 to 290°C

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Recommended distributors for this material

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