

# Toughblend® PC-1400

Polycarbonate

Colour Image Plastic Compound Sdn. Bhd. (CIPC)

## Message:

Toughblend® PC-1400 is a glass fiber reinforced compound characterized by good surface finish and high rigidity.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Surface Finish High Rigidity		
Uses	Camera Applications Engineering Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	100	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	5500	MPa	ASTM D790
Flexural Strength	165	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 4.00 mm)	140	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	275 to 280	°C	
Middle Temperature	280 to 285	°C	
Front Temperature	285 to 295	°C	
Nozzle Temperature	295 to 300	°C	
Processing (Melt) Temp	275 to 300	°C	
Mold Temperature	85.0 to 110	°C	

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#### Recommended distributors for this material

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