

Electrafil® PC 05004

Polycarbonate

Techmer Engineered Solutions

Message:

Electrafil® PC 05004 is a polycarbonate (PC) product. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Electromagnetic shielding (EMI)

General Information			
Features	Electromagnetic shielding (EMI)		
Appearance	Available colors		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	62.1	MPa	ASTM D638
Tensile Elongation (Break)	4.3	%	ASTM D638
Flexural Modulus	2680	MPa	ASTM D790
Flexural Strength	105	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	440	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	132	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0 - 1.0E+3	ohms	ASTM D257
Volume Resistivity	1.0 - 1.0E+3	ohms · cm	ASTM D257
Static Decay			FTMS 101B
Shielding Effectiveness - 30 to 1000 MHz	55	dB	ASTM D4935
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.18 mm)	V-1		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	302 - 316	°C	
Middle Temperature	316 - 332	°C	

Front Temperature	310 - 327	°C
Nozzle Temperature	310 - 327	°C
Processing (Melt) Temp	304 - 327	°C
Mold Temperature	71.1 - 87.8	°C
Injection Rate	Moderate	
Back Pressure	0.00 - 0.689	MPa

Injection instructions

Screw Speed: MediumRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.

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