

NEXUS PC/PBT PC/PBT7804

Polycarbonate + PBT
Nexus Resin Group, LLC.

Message:
Molding Grade PC/PBT

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.80 to 1.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1860	MPa	ASTM D638
Tensile Strength (Yield)	48.3	MPa	ASTM D638
Flexural Modulus	1970	MPa	ASTM D790
Flexural Strength (Yield)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	670	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	93.3	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	232 to 249	°C	
Middle Temperature	246 to 260	°C	
Front Temperature	246 to 266	°C	
Nozzle Temperature	246 to 266	°C	
Processing (Melt) Temp	252 to 274	°C	
Mold Temperature	48.9 to 87.8	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 75	rpm	

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