

OP - PC - Unfilled 20-FDA

Polycarbonate
Oxford Polymers

Message:

OP-PC-Unfilled 20-FDA is a polycarbonate (PC) material. This product is available in North America and is processed by injection molding. The main features of OP-PC-Unfilled 20-FDA are:
flame retardant/rated flame
accessible food
OP-PC-Unfilled 20-FDA's typical application areas are: food contact applications

General Information			
Features	Good liquidity		
	Compliance of Food Exposure		
Agency Ratings	FDA Food Exposure, Not Rated		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	23	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	65.5	MPa	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength	92.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (4°C)	640	J/m	ASTM D256
Dart Drop Impact	36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	129	°C	ASTM D648
1.8 MPa, not annealed	124	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.59 mm	V-2		UL 94
3.18 mm	V-2		UL 94
Additional Information			
Melt Mass - Flow Rate (MFR), ASTM D1238, 300°C/1.2kg: 20 to 25 g/10 min			
Injection	Nominal Value	Unit	

Drying Temperature	118 - 124	°C
Drying Time	3.0 - 4.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	249 - 271	°C
Middle Temperature	260 - 282	°C
Front Temperature	271 - 293	°C
Processing (Melt) Temp	266 - 293	°C
Mold Temperature	65.6 - 93.3	°C

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