

Sindustris PC SF1010

Polycarbonate
Sincerity Australia Pty Ltd.

Message:

Sindustris PC SF1010 is a Polycarbonate (PC) material. It is available in Asia Pacific for injection molding. Primary attribute of Sindustris PC SF1010: High Flow.
Typical applications include:
Housings
Electrical/Electronic Applications

General Information			
Features	General Purpose		
	High Flow		
Uses	Battery Cases		
	Cell Phones		
	Housings		
UL File Number	E306922		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	52	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	53.9	MPa	ASTM D638
Tensile Elongation ² (Yield, 3.20 mm)	> 50	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	83.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	80.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	3.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	240 to 250	°C	
Middle Temperature	250 to 280	°C	
Front Temperature	250 to 280	°C	
Nozzle Temperature	250 to 280	°C	

Processing (Melt) Temp	255 to 285	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

NOTE		
1.	5.0 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	

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Recommended distributors for this material

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