

KumhoSunny PC 3603

Polycarbonate

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

PC 3603 is a light diffusion resin. It offers good light diffusion and UV stability.

General Information			
Features	Good Light Diffusion		
	Good UV Resistance		
Uses	Automotive Applications		
	Electrical Parts		
	Electrical/Electronic Applications		
	LEDs		
	Lighting Applications		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.50 to 0.70	%	ASTM D955
--	0.50 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	65.0	MPa	ASTM D638, ISO 527-2/50
Tensile Elongation (Break)	110	%	ASTM D638
Flexural Modulus			
--	2300	MPa	ASTM D790
-- ¹	2300	MPa	ISO 178
Flexural Strength			
--	80.0	MPa	ASTM D790
-- ²	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	15	kJ/m ²	
23°C	60	kJ/m ²	

Charpy Unnotched Impact Strength ⁴ (23°C)	No Break		ISO 179
Notched Izod Impact			
3.20 mm	550	J/m	ASTM D256
23°C ⁵	55	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	130	°C	ASTM D648
1.8 MPa, Unannealed ⁶	121	°C	ISO 75-2/A
Vicat Softening Temperature	140	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Optical	Nominal Value	Unit	Test Method
Transmittance	40.0	%	ASTM D1003
Haze	99	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	240 to 270	°C	
Middle Temperature	250 to 290	°C	
Front Temperature	265 to 310	°C	
Nozzle Temperature	260 to 310	°C	
Processing (Melt) Temp	265 to 310	°C	
Mold Temperature	80.0 to 110	°C	
Back Pressure	0.200 to 0.800	MPa	
Screw Speed	20 to 100	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	4J		
4.	4J		
5.	5.5J		
6.	120°C/h		

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