

DynaStat® 1357X

Polycarbonate

Polymer Dynamix

Message:

Static Dissipative Polycarbonate

Features:

Carbon Free Static Dissipative Performance

Good Dimensional Stability

Excellent Processability

Applications:

Industrial

Electrical/Electronic Applications

Automotive

Packaging

General Information			
Additive	Antistatic property		
Features	Good dimensional stability		
	Antistatic property		
	Workability, good		
Uses	Packaging		
	Electrical/Electronic Applications		
	Industrial application		
	Application in Automobile Field		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	44.1	MPa	ASTM D638
Fracture	35.9	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	20	%	ASTM D638
Fracture	> 100	%	ASTM D638
Flexural Modulus	1720	MPa	ASTM D790
Flexural Strength	600	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	530 - 640	J/m	ASTM D256
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+8 - 1.0E+11	ohms	ASTM D257
Static Decay		sec	NFPA 99
Injection	Nominal Value	Unit	
Drying Temperature	104 - 121	°C	
Drying Time	3.0 - 5.0	hr	
Rear Temperature	221 - 232	°C	
Middle Temperature	227 - 238	°C	
Front Temperature	232 - 243	°C	
Nozzle Temperature	232 - 243	°C	
Processing (Melt) Temp	232 - 243	°C	
Mold Temperature	37.8 - 82.2	°C	
Injection Pressure	34.5 - 82.7	MPa	
Injection Rate	Moderate		
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Clamp Tonnage	4.1 - 6.9	kN/cm ²	
Extrusion	Nominal Value	Unit	
Drying Temperature	104 - 121	°C	
Drying Time	3.0 - 5.0	hr	
Cylinder Zone 1 Temp.	221 - 232	°C	
Cylinder Zone 3 Temp.	227 - 238	°C	
Cylinder Zone 5 Temp.	232 - 243	°C	
Melt Temperature	232 - 243	°C	
Die Temperature	232 - 243	°C	
Extrusion instructions			

Screw Speed: 25 to 100 RPM

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