

NEMCON H PC/ABS DP182

Polycarbonate + ABS

Ovation Polymers Inc.

Message:

Polycarbonate/Acrylonitrile Butadiene Styrene, thermally and electrically conducting grade.

General Information			
Features	Electrically Conductive Thermally Conductive		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.69	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.20	%	
Across Flow	0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (23°C)	4880	MPa	ASTM D638
Tensile Strength ² (Break, 23°C)	35.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 23°C)	1.4	%	ASTM D638
Flexural Modulus ⁴ (23°C, 50.0 mm Span)	3690	MPa	ASTM D790
Flexural Strength ⁵ (Break, 23°C, 50.0 mm Span)	57.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	19	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Thermal Conductivity			Internal Method
-- ⁶	0.80 to 1.1	W/m/K	
-- ⁷	4.0 to 8.0	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	3.0E+6	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	230 to 240	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	250 to 260	°C	
Nozzle Temperature	260 to 270	°C	
Processing (Melt) Temp	255 to 265	°C	

Mold Temperature	90.0 to 100	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.138	MPa
Screw Speed	60 to 80	rpm

NOTE

1.	50 mm/min
2.	50 mm/min
3.	50 mm/min
4.	1.3 mm/min
5.	1.3 mm/min
6.	Through Plane
7.	In Plane

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