

NEMCON H PC DP164

Polycarbonate
Ovation Polymers Inc.

Message:
PC based, thermally conducting, electrically insulating grade with improved processability.

General Information			
Features	Electrically Insulating		
	Good Processability		
	Thermally Conductive		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (23°C)	3950	MPa	ASTM D638
Tensile Strength ² (Break, 23°C)	27.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 23°C)	1.2	%	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)	38.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Thermal Conductivity			Internal Method
23°C ⁶	1.3 to 1.5	W/m/K	
23°C ⁷	5.5 to 8.0	W/m/K	
Injection	Nominal Value	Unit	
Drying Temperature	100	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	250 to 260	°C	
Middle Temperature	260 to 270	°C	
Front Temperature	260 to 280	°C	
Nozzle Temperature	270 to 290	°C	
Processing (Melt) Temp	270 to 290	°C	
Mold Temperature	110 to 130	°C	
Back Pressure	0.414 to 0.689	MPa	
Screw Speed	60 to 120	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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