

# NEXUS PC PCGF10

Polycarbonate  
Nexus Resin Group, LLC.

Message:  
Molding Grade PC With 10% Glass

| General Information                                              |                                  |                   |             |
|------------------------------------------------------------------|----------------------------------|-------------------|-------------|
| Filler / Reinforcement                                           | Glass Fiber,10% Filler by Weight |                   |             |
| Processing Method                                                | Injection Molding                |                   |             |
| Physical                                                         | Nominal Value                    | Unit              | Test Method |
| Specific Gravity                                                 | 1.27                             | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)                         | 15                               | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow                                         | 0.30 to 0.50                     | %                 | ASTM D955   |
| Mechanical                                                       | Nominal Value                    | Unit              | Test Method |
| Tensile Modulus                                                  | 3100                             | MPa               | ASTM D638   |
| Tensile Strength (Yield)                                         | 65.5                             | MPa               | ASTM D638   |
| Flexural Modulus                                                 | 3100                             | MPa               | ASTM D790   |
| Flexural Strength (Yield)                                        | 100                              | MPa               | ASTM D790   |
| Impact                                                           | Nominal Value                    | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                              | 53                               | J/m               | ASTM D256   |
| Thermal                                                          | Nominal Value                    | Unit              | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm) | 135                              | °C                | ASTM D648   |
| Injection                                                        | Nominal Value                    | Unit              |             |
| Drying Temperature                                               | 121                              | °C                |             |
| Drying Time                                                      | 4.0                              | hr                |             |
| Suggested Max Moisture                                           | 0.020                            | %                 |             |
| Rear Temperature                                                 | 288 to 316                       | °C                |             |
| Middle Temperature                                               | 302 to 329                       | °C                |             |
| Front Temperature                                                | 316 to 343                       | °C                |             |
| Nozzle Temperature                                               | 316 to 343                       | °C                |             |
| Processing (Melt) Temp                                           | 316 to 343                       | °C                |             |
| Mold Temperature                                                 | 10.0 to 93.3                     | °C                |             |
| Back Pressure                                                    | 0.276 to 0.689                   | MPa               |             |
| Screw Speed                                                      | 25 to 75                         | rpm               |             |

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