

# DIAMALLOY ENGINEERED ALLOYS PCPBT 530

Polycarbonate + PBT  
Network Polymers, Inc.

Message:

DIAMALLOY ENGINEERED ALLOYS PCPBT 530 is a Polycarbonate + PBT (PC+PBT) product. It is available in North America.  
Characteristics include:  
Good Weather Resistance  
UV Stabilized

General Information			
Additive	UV Stabilizer		
Features	Good Weather Resistance		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) <sup>1</sup> (265°C/5.0 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.60 to 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	62.1	MPa	ASTM D638
Flexural Modulus <sup>3</sup>	2450	MPa	ASTM D790B
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	750	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	102	°C	ASTM D648
Vicat Softening Temperature	133	°C	ASTM D1525 <sup>4</sup>
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	104 to 110	°C	
Drying Time - Desiccant Dryer	4.0 to 6.0	hr	
Dew Point - Desiccant Dryer	< -28.9	°C	
Suggested Shot Size	60 to 80	%	
Suggested Max Regrind	20	%	
Rear Temperature	243 to 266	°C	
Middle Temperature	254 to 277	°C	
Front Temperature	260 to 282	°C	
Nozzle Temperature	260 to 288	°C	
Processing (Melt) Temp	260 to 288	°C	
Mold Temperature	54.4 to 82.2	°C	
Injection Rate	Slow-Moderate		
Holding Pressure	0.345 to 0.517	MPa	
Back Pressure	0.552 to 1.03	MPa	
Screw Speed	50 to 75	rpm	

Clamp Tonnage	4.1 to 6.9	kN/cm <sup>2</sup>
Cushion	2.54 to 7.62	mm
NOTE		
1.	Procedure A	
2.	Type I, 51 mm/min	
3.	Method I (3 point load), 1.3 mm/min	
4.	Rate B (120°C/h), Loading 1 (10 N)	

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#### Recommended distributors for this material

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