

OP - PC - Unfilled 68

Polycarbonate

Oxford Polymers

Message:

OP-PC-Unfilled 68 is a polycarbonate (PC) material. This product is available in North America and is processed by injection molding. The main characteristics of OP-PC-Unfilled 68 are: flame retardant/rated flame.

General Information			
Features	Low liquidity		
	General		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	72.4	MPa	ASTM D638
Flexural Modulus	2310	MPa	ASTM D790
Flexural Strength	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (4°C)	910	J/m	ASTM D256
Dart Drop Impact	36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	138	°C	ASTM D648
1.8 MPa, not annealed	132	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.59 mm	V-2		UL 94
3.18 mm	V-2		UL 94
Additional Information			
Melt Mass - Flow Rate (MFR), ASTM D1238, 300°C/1.2kg: 6 to 9 g/10 min			
Injection	Nominal Value	Unit	
Drying Temperature	118 - 124	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	

Rear Temperature	288 - 310	°C
Middle Temperature	299 - 321	°C
Front Temperature	310 - 332	°C
Processing (Melt) Temp	316 - 343	°C
Mold Temperature	82.2 - 116	°C

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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