

# Color-in™ PC-M

Polycarbonate

Shanghai KumhoSunny Plastics Co., Ltd.

## Message:

PC-M is injection a molding aesthetic resin.PC-M is a color creativity plan.PC-M can be used for high degree of color and semitransparent design.PC-M is mainly used in appearance items of household appliance,etc.

| General Information                                     |                             |                   |                         |
|---|-----------------------------|-------------------|-------------------------|
| Features  | Pleasing Surface Appearance |                   |                         |
| Uses  | Appliances                  |                   |                         |
| Forms   | Pellets                     |                   |                         |
| Processing Method                                       | Injection Molding           |                   |                         |
| Physical  | Nominal Value               | Unit              | Test Method             |
| Specific Gravity  | 1.20                        | g/cm <sup>3</sup> | ASTM D792               |
| Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)                | 30                          | g/10 min          | ASTM D1238              |
| Molding Shrinkage - Flow                                | 0.50 to 0.70                | %                 | ASTM D955               |
| Hardness  | Nominal Value               | Unit              | Test Method             |
| Rockwell Hardness (R-Scale)                             | 120                         |                   | ASTM D785               |
| Pencil Hardness - 500g                                  | HB                          |                   |                         |
| Mechanical  | Nominal Value               | Unit              | Test Method             |
| Tensile Strength  | 60.0                        | MPa               | ASTM D638               |
| Flexural Modulus  | 2300                        | MPa               | ASTM D790               |
| Flexural Strength                                       | 80.0                        | MPa               | ASTM D790               |
| Impact  | Nominal Value               | Unit              | Test Method             |
| Notched Izod Impact (3.20 mm)                           | 300                         | J/m               | ASTM D256               |
| Thermal   | Nominal Value               | Unit              | Test Method             |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 110                         | °C                | ASTM D648               |
| Vicat Softening Temperature                             | 125                         | °C                | ASTM D1525 <sup>1</sup> |
| Electrical  | Nominal Value               | Unit              | Test Method             |
| Surface Resistivity                                     | > 1.0E+15                   | ohms              | IEC 60093               |
| Volume Resistivity                                      | > 1.0E+15                   | ohms · cm         | IEC 60093               |
| Flammability  | Nominal Value               | Unit              | Test Method             |
| Flame Rating (1.60 mm)                                  | V-2                         |                   | UL 94                   |
| Injection   | Nominal Value               | Unit              |                         |
| Drying Temperature                                      | 100 to 120                  | °C                |                         |
| Drying Time   | 3.0 to 4.0                  | hr                |                         |
| Suggested Max Moisture                                  | 0.030                       | %                 |                         |
| Rear Temperature  | 250 to 260                  | °C                |                         |
| Middle Temperature                                      | 240 to 265                  | °C                |                         |
| Front Temperature                                       | 240 to 265                  | °C                |                         |

|                        |               |     |
|------------------------|---------------|-----|
| Nozzle Temperature     | 240 to 250    | °C  |
| Processing (Melt) Temp | 250 to 265    | °C  |
| Mold Temperature       | 85.0 to 95.0  | °C  |
| Back Pressure          | 0.300 to 1.00 | MPa |
| Screw Speed            | 40 to 55      | rpm |

NOTE

1. Rate B (120°C/h)

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