

## PRODUCT DATA SHEET

Global

Processing Method

Injection Molding

Description

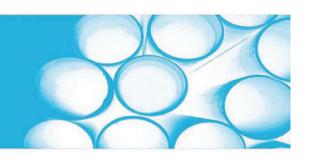
General purpose PC

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.2 g/cm3	ASTM D792
Melt Mass-Flow Rate	7 g/10 min	ASTM D1238
Mechanical	Nominal Value	Test Method
Tensile Modulus	2350 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	63 MPa	
Break	65 MPa	
Tensile Elongation		ASTM D638
Yield	7%	
Break	110%	
Flexural Modulus	2300 Mpa	ASTM D790
Flexural Strength	93 MPa	ASTM D790
Impact	Nominal Value	Test Method
Notched Izod Impact	900 J/m	ASTM D256

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.







Thermal	Nominal Value	Test Method
HDT, 1.82 MPa, 3.2mm, Unannealed	124 C	ASTM D648
CTE, -40C to 95C, flow	1/C	ASTM E831
Flammability		
Flame Rating (1.5mm)	НВ	UL 94
Injection Processing		Nominal Value
Drying Temperature		120 C
Drying Time		3 to 4 hours
Suggested Max Moisture		0.02%
Rear Temperature		290 to 310 C
Middle Temperature		300 - 320 C
Front Temperature		310 - 330 C
Nozzle Temperature		305 - 330 C
Processing (melt) Temperature		310 - 330 C
Mold Temperature		80 - 115 C
Back Pressure		.307 MPa
Screw Speed		40 to 70 rpm
Vent Depth		.025076 mm

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