

PC-M

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.

| Properties | Standard | Unit | Condition | Typical Value |
|---|------------|---------|---------------|---------------|
| Physical | | | | |
| Density | ASTM D792 | g/cm3 | | 1.2 |
| Melt Index | ASTM D1238 | g/10min | 260℃×5kg | 30 |
| Mold Shrinkage | ASTM D955 | % | | 0.5~0.7 |
| Gloss | ASTM D523 | % | | / |
| Mechanical | | | | |
| Tensile Strength | ASTM D638 | MPa | | 60 |
| Flexural Strength | ASTM D790 | MPa | | 80 |
| Flexural Modulus | ASTM D790 | MPa | | 2300 |
| Notched Izod Impact,3.2mm | ASTM D256 | J/m | 3.2mm,Notched | 300 |
| Rockwell Hardness | ASTM D785 | R | | 120 |
| Pencil Hardness | ASTM D2179 | / | 500g | HB |
| Thermal | | | | |
| Heat Deflection Temp. 1.82MPa Unannealed | ASTM D648 | ℃ | 1.82MPa | 110 |
| VICAT | ASTM D1525 | ℃ | B | 125 |
| Flammability | | | | |
| Flammability | UL-94 | Class | 1.6mm | V-2 |
| Electrical Properties | | | | |
| Volume Resistivity | IEC 60093 | Ohm-cm | / | > 1.0E+15 |
| Surface Resistivity | IEC 60093 | Ohm | / | > 1.0E+15 |

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| Processing Parameters | Typical Value | Unit |
|---------------------------------|----------------------|-------------|
| Drying Temperature | 100~120 | ℃ |
| Drying Time | 3~4 | hour |
| Maximum moisture content | 0.03 | % |
| Barrel Temperature | | |
| Rear | 250~260 | ℃ |
| Middle | 240~265 | ℃ |
| Front | 240~265 | ℃ |
| Nozzle | 240~250 | ℃ |
| Melt Temperature | 250~265 | ℃ |
| Mold Temperature | 85~95 | ℃ |
| Back Pressure | 0.3~1.0 | MPa |
| Screw Speed | 40~55 | rpm |

Note:

1)The above data is only for reference. Exact settings have to follow the product,injection machine and mold.

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