

WONDERLOY[®]

PC alloy, general purpose injection molding application

PROPERTIES	CONDITION	PC-330	PC-345	PC-365	PC-385	UNIT	METHOD
<u>PHYSICAL</u>							
Melt Flow Index	260°C/5kg	13	17	20	20	g/10min	ASTM D-1238
Spiral Flow Length	260°C, 2mm V:50%,	35	33	30	28	cm	Chimei method
Specific Gravity	P:50% 23°C	1.08	1.10	1.13	1.15	-	ASTM D-792
Mold Shrinkage	-	0.4~0.6	0.4~0.6	0.4~0.6	0.4~0.6	%	ASTM D-955
Rockwell Hardness	23°C	R-108	R-108	R-115	R-114	-	ASTM D-785
CLTE	Flow:-40°C-40°C	9.0E-06	8.5E-06	8.0E-05	7.5E-05	cm/cm/°C	ASTM E-831
<u>MECHANICAL</u>							
Tensile Strength @ Yield	50mm/min	500	500	540	540	kg/cm ²	ASTM D-638
Tensile Elongation @ Break	50mm/min	85	85	85	90	%	ASTM D-638
Flexural Strength	1.3mm/min	750	750	800	800	kg/cm ²	ASTM D-790
Flexural Modulus	1.3mm/min	23,000	23,000	23,000	23,500	kg/cm ²	ASTM D-790
Izod Impact (1/8")	Notched, 23°C	45	50	55	60	kg-cm/cm	ASTM D-256
Izod Impact (1/8")	Notched, -30°C	40	45	50	50	kg-cm/cm	ASTM D-256
<u>THERMAL</u>							
Heat Distortion Temp. (unannealed)	3.2mm, 1.82Mpa 120°C/hr	88	95	106	110	°C	ASTM D-648
	6.4mm, 1.82Mpa 120°C/hr	98	105	115	118		
Vicat Softening Temp. (unannealed)	1kg, 50°C/hr	118	125	136	140	°C	ASTM D-1525
	5kg, 50°C/hr	108	110	125	133		
<u>ELECTRICAL</u>							
Dielectric Constant	1 MHz	3.1	3.1	3.1	3.0	-	IEC 60250
Volume Resistivity	-	1E+16	1E+16	1E+16	1E+16	Ohm*m	IEC 60093
Surface Resistivity	-	1E+16	1E+16	1E+16	1E+16	Ohm	IEC 60093
<u>FLAMMABILITY</u>							
Flame Rating_HB		1.5	1.5	1.5	1.5	mm	UL-94
<u>PROCESSING PARAMETERS</u>							
Drying Temperature		80~100	80~100	80~100	80~100	°C	
Drying Time		4	4	4	4	Hrs	
Barrel Temperature		230~270	230~270	230~270	240~280	°C	
Mold Temperature		50~100	50~100	50~100	50~100	°C	

All figures listed here is for reference, not guaranteed.

Final revised date: 2014/6

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