

## Technical Data Sheet

### *Polyflam* 54N5006NC SF



Polycarbonate

#### Product Description

*Polyflam* 54N5006NC SF is a Polycarbonate material and is typically used in Injection Molding applications.

<b>Processing Method</b>	Injection Molding
<b>Forms</b>	Pellets
<b>Additive</b>	Flame Retardant

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Flow Rate, (300 °C/1.2 kg)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.23	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield	60.7	MPa	ASTM D638
Flexural Modulus	2240	MPa	ASTM D790
<b>Impact</b>			
Gardner Impact	>36.2	J	ASTM D5420
Notched Izod Impact	690	J/m	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	127	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	129	°C	ASTM D648
RTI Str	115	°C	UL 746B
<b>UL Information</b>			
Flame Rating, (1.5 mm)	V-0		UL 94

Injection Parameters	Nominal Value	Units
Drying Time	4	hr
Drying Temperature	121	°C
Screw Speed	40 to 75	rpm
Processing (Melt) Temp	282 to 299	°C
Front Temperature	249 to 299	°C
Middle Temperature	249 to 299	°C
Rear Temperature	249 to 299	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.345 to 0.689	MPa
Mold Temperature	71 to 104	°C
Cushion	6.35 to 12.7	mm