

**Technical Data Sheet**

***Polyflam* PC 510GF BLK SF**



Polycarbonate

**Product Description**

Flame Retardent, 10% Glass Reinforced, Polycarbonate

**Processing Method**            Injection Molding

**Additive**                      Flame Retardant

<b>Typical Properties</b>	<b>Nominal Value</b>	<b>Units</b>	<b>Test Method</b>
<b>Physical</b>			
Melt Flow Rate, (300 °C/2.16 kg)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.27	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield, (50 mm/min)	55.0	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min)	3100	MPa	ASTM D790
<b>Impact</b>			
Notched Izod Impact	120	J/m	ASTM D256
<b>UL Information</b>			
Flame Rating			
(1.5 mm)	V-0		UL 94
(2.5 mm)	5VA		UL 94
(3.4 mm)	5VA		UL 94

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Temperature	121	°C
Suggested Max Moisture	<0.020	%
Nozzle Temperature	249 to 288	°C
Screw Speed	40 to 75	rpm
Processing (Melt) Temp	249 to 288	°C
Front Temperature	249 to 288	°C
Middle Temperature	249 to 288	°C
Rear Temperature	249 to 277	°C
Back Pressure	<0.689	MPa
Mold Temperature	71 to 104	°C